



CEWELD E 8018-C1

TYPE	Basic Ni alloyed low hydrogen electrode for stick welding	
ANWENDUNGEN	Low temperature applications, Refrigerated ammonia tanks, Liquefied gas storage, piping and transportation, Weathering steels	
EIGENSCHAFTEN	Excellent arc stability and easy slag removal with low spatter losses. Developed for high impact strength properties at extreme sub zero temperatures. Hydrogen content is less than HD < 4 ml/100gr weldmetal.	
KLASSIFIKATION	AWS	A 5.5: E 8018-C1
	EN ISO	2560-A: E 50 8 2Ni B 42 H5
	F-nr	4
	FM	1
GEEIGNET FÜR	Reh ≤ 500 MPa ISO 15608: 1.2, 1.3, 2.1, 9.2 1.5637, 1.6217, 1.6228, 1.0044-1.09821.0035 - 1.0570, 1.0345, 1.0425, 1.0481, 1.0308 - 1.0581, 1.0307 - 1.0582, 1.0440, 1.0472, 1.0475, 1.0416 to 1.0551 10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6, S275N-S460N, S275NL-S460NL, S275M-S460M, S275ML-S460ML, P275NL1-P460NL1, P275NL2-P460NL2 ASTM A 203 Gr. D, E; A 333 Gr. 3; A334 Gr. 3; A 350 Gr. LF1, LF2, LF3; A 420 Gr. WPL3, WPL6; A 516 Gr. 60, 65; AA 529 Gr. 50; A 572 Gr. 42, 65; A 633 Gr. A, D, E; A 662 Gr. A, B, C; A 707 Gr. L1, L2, L3; A 738 Gr. A; A 841 A, B, C NFA 35-207: A510PP1 – A550PP2 NFA 36208: 3.5 Ni 285 ct 355 (12N14) OPTIM 500ML, PAS 65 us, PAS 70 us, Dilimax 500, Dilimax 550, Weldox 500	

ZULASSUNGEN CE

SCHWEISSPOSITIONEN



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Ni
0.05	0.5	1	0.015	0.015	2.3

MECHANISCHE GÜTEWERTE

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-20°C	-80°C	
As Welded	530	630	24	80	60	HRC

RÜCKTROCKNUNG 400°C / 1 hr

GAS ACC. EN ISO 14175



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E 8018-C1 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,6	8720663401298