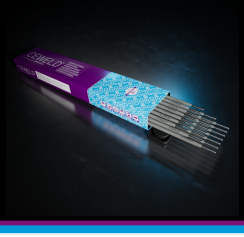


CEWELD E 7018-A1

certilas® THE FILLER METAL SPECIALIST

TYPE

Basic low hydrogen electrode with 0.5% Mo. (Type E Mo, A1)

APPLICATIONS

CEWELD® E 7018-A1 provides a 0.5%Mo alloyed weld metal. CEWELD® E 7018-A1 can also be used for heat-treated welds. The range of applications extends from joint welding of similar heat-resistant steels and cast steel to joint welding of high-strength structural, fine-grained and pipeline steels with a yield strength of up to 460 MPa.

PROPERTIES

CEWELD® E 7018-A1 is approved for application temperatures up to 550 °C in the long-term range and shows excellent notched bar impact work at temperatures - 40°C. It is characterized by low moisture absorption and guarantees a low diffusible hydrogen content in the weld metal as well as a yield of 115 %.

CLASSIFICATION

AWS	A 5.5: E 7018-A1
EN ISO	3580-A: E Mo B 42 H5
F-nr	4
FM	3

SUITABLE FOR

Typ 0,5Mo ISO 15608: ≤ 460 MPa ; 1.1, 1.2,(~1.3)
1.5415, 1.0481, 1.0482
15 Mo3, 16Mo3, 20MnMoNi4-5, 15NiCuMoNb5, S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE300
ASTM: A 29 Gr. 1013, 1016; A 106 Gr. C; A, B; A 182 Gr. F1; A 234 Gr. WP1; A 283 Gr. B, C, D; A 335 Gr. P1; A 501 Gr. B; A 533 Gr. B, C; A 510 Gr. 1013; A 512 Gr. 1021, 1026; A 513 Gr. 1021, 1026; A 516 Gr. 70; A 633 Gr. C; A 678 Gr. B; A 709 Gr. 36, 50; A 711 Gr. 1013;
API 5 L B, X42, X52, X60, X65

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Mo
0.09	0.5	0.8	0.025	0.02	0.5

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-20°C	-40°C	
As Welded	470	560	25	75	60	HRc

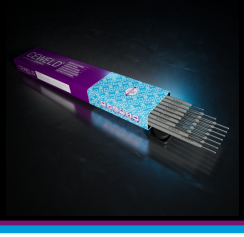
REDRYING

400°C / 1 hr

CURRENT TYPE:

AC, DC+

GAS ACC. EN ISO 14175



CEWELD E 7018-A1

E 7018-A1 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	2,4	8720663401182

E 7018-A1 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,4	8720663401205

E 7018-A1 4,0 X 450MM

Packaging	KG/unit	EanCode
Can	3,2	8720663401229

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