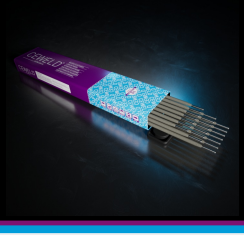

CEWELD E 6018 LC

certilas® THE FILLER METAL SPECIALIST

TYPE

High basic extra low hydrogen electrode for stick welding.

APPLICATIONS

Pipe work, shipbuilding, buffer layers, vessel construction, difficult metallurgical joints, mechanical engineering.

PROPRIÉTÉS

Extremely crack resistant weld metal conditioned by the high basic slag. Low spatter loss, easy slag removal. Well suited for joining high carbon steels and when welding critical mixed base metal combinations. Ideal metallurgical choice for repair welding and production as well as for use as a buffer layer. Developed for repair welding of pipes using half shells or T split joints. Extreme low hydrogen content HD <3ml/100gr.

CLASSIFICATION

AWS	A 5.1: E 6018
EN ISO	2560-A: E 35 4 B 32 H5
F-nr	4
FM	1

CONVIENT POUR

Re ≤355 MPa (51 ksi (67 ksi) ISO 15608: 1.1, 1.2
S235JR-E295, S235J2G3 - S355J2G3, C22, P235T1-P275T1, P235T2, P275T2, L210 - L320, L290MB - L320MB, P235G1TH, P255G1TH, P235GH, P265GH, P295GH, S235JRS1 - S235J4S, S355G1S - S355G3S, S255N - S355N, P255NH-P355NH, S255NL - S355NL, GE200-GE240
ASTM: A 27 u. A36 Gr. alle; A214; A 242 Gr.1-5; A266 Gr. 1, 2, 4; A283 Gr. A, B, C, D; A285 Gr. A, B, C; A299 Gr. A, B; A328; A366; A515 Gr. 60, 65, 70; A516 Gr. 55; A570 Gr. 30, 33, 36, 40, 45; A 572 Gr. 42, 50; A606 Gr. Alle; A607 Gr. 45; A656 Gr. 50, 60; A668 Gr. A, B; A907 Gr. 30, 33, 36, 40; A841; A851 Gr. 1, 2; A935 Gr.45; A936 Gr. 50;
API 5 L Gr. B, X42-X52

AGRÉMENTS

CE

POSITIONS DE SOUDAGE

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S
0.02	0.27	0.42	0.02	0.01

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V -20°C	Hardness
As Welded	400	520	25	200	HRc

ETUVAGE

400°C / 1 hr

GAS ACC. EN ISO 14175