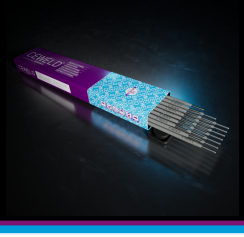


CEWELD E 10018-G

certilas® THE FILLER METAL SPECIALIST

TYPE

Ultra low hydrogen high basic offshore electrode for high strength fine grain steels.

APPLICATIONS

Designed for welding steels with tensile strength <690 MPa in offshore, crane building, heavy transport, lifting etc.

PROPERTIES

Mn, Ni, Cr and Mo alloyed basic electrode for welding low alloyed steels with tensile strength > 620 MPa. Crack resistant and well suited for low-temperatures, ductility down to -50°C. Preheating, interpass temperature and post weld treatment as required for the base metal. Hydrogen content: < 3 ml / 100 g weld metal.

CLASSIFICATION

AWS	A 5.5: E 10018-G
EN ISO	18275-A: E 62 5 1,5NiMo B 42 H5
F-nr	4
FM	2

SUITABLE FOR

≤ 620 MPa ISO 15608: 2.2, 3.1 (360 < ReH ≤ 620 MPa)
S500Q-S620Q, S500QL-S620QL, S500QL1-S620QL1, L485MB-L555MB, L485QB-L555QB, alform 500 M, 550 M, 600 M, aldur 550 Q, 550 QL, 550 QL1, Weldox 500-600, Dillimax 500-600, Naxtra
ASTM A 572 Gr. 65; A 633 Gr. E; A 738 Gr. A; A 852; A 514 M Grade A, B, A 537 M, A
API 5 L X70, X80, X70Q, X80Q
Naxtra 63, Weldox 500, Domex 460 MC, Domex 500 MC, Domex 550 MC, Domex 600 MC, Domex 650 MC, L480 - L550, X65 - X80, Hardox 400, XAR 400, Dilidur 400,

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Ni	Mo
0.06	0.6	1.25	1.4	0.4

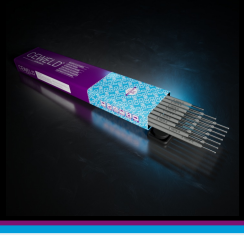
MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V -50°C	Hardness
As Welded	690	780	20	62	HRc

REDRYING

400°C / 1 hr

GAS ACC. EN ISO 14175



CEWELD E 10018-G

E 10018-G 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,5	8720663416520

E 10018-G 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663416544

E 10018-G 4,0 X 450MM

Packaging	KG/unit	EanCode
Can	3,1	8720663416568