



# CEWELD E 12018-Mo

**TYPE** Extremely high-strength (< 890/960 MPa) basic coated offshore stick electrode with extremely low H2 content in the weld metal ( Type 12018 )

**APPLICATIONS** CEWELD® E 12018-Mo is designed for welding heat-treatable steels with a yield strength of up to 960 MPa such as S960QL and S960V in crane construction, heavy earthmoving machinery etc. in compliance with the T8/5 time.

**PROPERTIES** CEWELD® E 12018-Mo has excellent welding properties and a hydrogen content HD < 4 ml/100g in the weld metal.

**CLASSIFICATION**

AWS	A 5.5: E 12018-G
EN ISO	18275-A: E 89 Z B 32 H5
F-nr	4
FM	2

**SUITABLE FOR** **Reh < 890 Mpa Iso 15608: 3.2 (Reh > 690 MPa)**  
 S960QL, TSTE 960V, Xabo 90, X96, Weldox 900 Weldox 1100, Domex 960, Domex Wear 360, XABO 90, StE890V, StE960TM, weldox 900, StE 890, S890QL1, A517, X120, StE 960, S960QL1, S1100 (till 12 mm)  
 alform plate 900 x-treme, alform plate 960 M x-treme

**APPROVALS** CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	Cr	Ni	Mo
0.063	0.42	1.41	0.88	2.33	0.75

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	Hardness
				-40°C	
As Welded	925	1050	17	75	HRc

**REDRYING** 350°C / 2 hr

**GAS ACC. EN ISO 14175**



# CEWELD E 12018-Mo

E 12018-MO 2,5 X 300MM	Packaging	KG/unit	EanCode
	Vacuum	1,8	8720682050453
E 12018-MO 3,2 X 350MM	Packaging	KG/unit	EanCode
	Vacuum	1,9	8720682050460
E 12018-MO 4,0 X 450MM	Packaging	KG/unit	EanCode
	Vacuum	2,4	8720682050477
E 12018-MO 5,0 X 450MM	Packaging	KG/unit	EanCode
	Vacuum	2,3	8720682050484