



CEWELD E 11018-H

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

APPLICATIONS Designed for welding steels with high yield 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 yield strength > 690 MPa. Crack resistant and well suited for low-temperatures, ductility down to -60°C. Preheating, interpass temperature and post weld treatment as required for the base metal. Hydrogen content: HD < 3 ml / 100 g weld metal. CEWELD E 11018-H is packed in the best in class multi layer vacuum pack to avoid costly and time consuming redrying of the electrodes.

CLASSIFICATION

AWS	A 5.5: E 11018-M
EN ISO	18275-A: E 69 6 Mn2NiCrMo B 42 H5
F-nr	4
FM	2

SUITABLE FOR

Reh < 690 MPa Iso 15608: 3.2 (460 < Reh ≤ 690 MPa)
 1.8914, 1.8927, 1.8931, 1.8928, 1.7147, 1.7149, 1.8734
 S620Q, S620QL, S690Q, S690QL, S620QL1-S690QL1, 20MnCr65, 28CrMn4-3
 L480 - L550, X65, X80, X90, X100
 ASTM A 514 Gr. F, H, Q; A 709 Gr. 100 Type B, E, F, H, Q; A 709 Gr. HPS 100W
 Weldox 700, Dillimax 690, Hardox, Naxtra 63, Naxtra 70, Optim 700 mc plus, Weldox 500, Hardox,
 Domex 460 MC, Domex 500 MC, Domex 550 MC, Domex 600 MC, Domex 650 MC, Domex 700 MC,
 Hardox 400, XAR 400, Dillidur 400, Oceanfit 100, Oceanfit 690, alform plate 620 M, 700 M, aldur 620
 Q, 620 QL, 620 QL1, aldur 700 Q, 700 QL, 700 QL1

APPROVALS CE, DNV, Lloyds

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	V	Cu	Nb
0.056	0.34	1.42	0.28	2.27	0.304	0.01	0.06	0.006

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-60°C	-40°C	
As Welded	730	810	22	75	90	HRC

REDRYING 400°C / 1 hr

GAS ACC. EN ISO 14175



CEWELD E 11018-H

E 11018-H 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	1,6	8720663416582

E 11018-H 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663416605

E 11018-H 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663416629