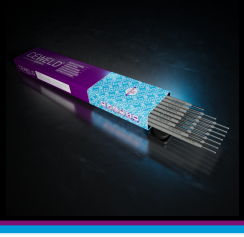

# CEWELD E 10018-D2

certilas® THE FILLER METAL SPECIALIST

**TYPE**

High basic MnMo Stickelektrode with low hydrogen electrode for high strength steels. (Type 10018-D2, E 62 4)

**APPLICATIONS**

CEWELD® E 10018-D2 is recommended for welding high yield strength steel (> 600 MPa) in case high impact values are required at sub zero temperatures. The ideal electrode for welding MUD pipes in offshore. (Meets NACE requirements) Pipeline according API standard ranging from X65 up to X80.

**PROPERTIES**

CEWELD® E 10018-D2 is a basic electrode with excellent welding characteristics, Hydrogen content HD < 3 ml/100 g. Meets NACE requirements MR0175/ISO15156-2.

**CLASSIFICATION**

| | |
|---|---|
| AWS | A 5.5: E 10018-D2 |
| EN ISO | 18275-A: E 62 4 MnMo B 42 H5 |
| F-nr | 2 |
| FM | 4 |

**SUITABLE FOR**

**< 620 MPa ISO 15608: 2.2, 3.1 (360 < ReH ≤ 690 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 | Mo |
|---|---|---|---|
| 0.07 | 0.4 | 1.9 | 0.4 |

**MECHANICAL PROPERTIES**

| Heat Treatment | $R_{P0,2}$ (MPa) | Rm (MPa) | A5 (%) | Impact Energy (J) ISO-V -40°C | Hardness |
|---|---|---|---|---|---|
| As Welded | 640 | 790 | 20 | 75 | HRc |
| 620°C±15°C 1h | 690 | 740 | 24 | 60 | HRc |

**REDRYING**

400°C / 1 hr

**GAS ACC. EN ISO 14175**