



CEWELD E 12018-Mo

TYPE Low hydrogen basic electrode for extreme high strength steels

APPLICATIONS Designed for welding heat treated steels with yield strength > 960 MPa such as S960QL and TsTE960V in crane building, heavy lifting earth moving equipment etc.

PROPRIÉTÉS Basic electrode with excellent welding characteristics, recommended for welding fine grained similar alloyed high yield strength steel > 960 MPa in case high impact values are required at sub zero temperatures. Hydrogen content HD < 4 ml/100 g.

CLASSIFICATION

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

CONVIENT POUR **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

AGRÉMENTS CE

POSITIONS DE SOUDAGE



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

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

PROPRIÉTÉS MÉCANIQUES

| Heat Treatment | R _{P0.2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--|----------|
| | | | | -40°C | | |
| As Welded | 925 | 1050 | 17 | 75 | | HRc |

ETUVAGE 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 |