




# CEWELD E 8018-C1

| TYPE  | Electrode 8018-C1 à faible teneur en hydrogène et alliage de Ni basique pour le soudage par bâtonnets  |                |                  |          |                            |                         |        |          |                         |       |           |       |     |    |    |    |     |
|---|--|----------------|------------------|----------|----------------------------|-------------------------|--------|----------|-------------------------|-------|-----------|-------|-----|----|----|----|-----|
| APPLICATIONS                                | Applications à basse température, réservoirs d'ammoniac réfrigérés, stockage, tuyauterie et transport de gaz liquéfiés, aciers résistant aux intempéries   |                |                  |          |                            |                         |        |          |                         |       |           |       |     |    |    |    |     |
| PROPRIÉTÉS                                  | Excellente stabilité de l'arc et élimination facile du laitier avec de faibles pertes de projections. Développé pour des propriétés de résistance aux chocs élevées à des températures extrêmes inférieures à zéro. La teneur en hydrogène est inférieure à HD < 4 ml/100gr de métal soudé.  |                |                  |          |                            |                         |        |          |                         |       |           |       |     |    |    |    |     |
| CLASSIFICATION                              | <table border="0"> <tr> <td>AWS</td> <td>A 5.5: E 8018-C1</td> </tr> <tr> <td>EN ISO</td> <td>2560-A: E 50 8 2Ni B 42 H5</td> </tr> <tr> <td>F-nr</td> <td>4</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table>   | AWS            | A 5.5: E 8018-C1 | EN ISO   | 2560-A: E 50 8 2Ni B 42 H5 | F-nr                    | 4      | FM       | 1                       |       |           |       |     |    |    |    |     |
| AWS   | A 5.5: E 8018-C1   |                |                  |          |                            |                         |        |          |                         |       |           |       |     |    |    |    |     |
| EN ISO                                      | 2560-A: E 50 8 2Ni B 42 H5   |                |                  |          |                            |                         |        |          |                         |       |           |       |     |    |    |    |     |
| F-nr  | 4  |                |                  |          |                            |                         |        |          |                         |       |           |       |     |    |    |    |     |
| FM  | 1  |                |                  |          |                            |                         |        |          |                         |       |           |       |     |    |    |    |     |
| CONVIENT POUR                               | <p><b>Reh ≤ 500 MPa ISO 15608: 1.2, 1.3, 2.1, 9.2</b><br/>           1.5637, 1.6217, 1.6228, 1.0044-1.09821.0035 - 1.0570, 1.0345, 1.0425, 1.0481, 1.0308 - 1.0581, 1.0307 - 1.0582, 1.0440, 1.0472, 1.0475, 1.0416 to 1.0551<br/>           10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6, S275N-S460N, S275NL-S460NL, S275M-S460M, S275ML-S460ML, P275NL1-P460NL1, P275NL2-P460NL2<br/> <b>ASTM A 203 Gr. D, E; A 333 Gr. 3; A334 Gr. 3; A 350 Gr. LF1, LF2, LF3; A 420 Gr. WPL3, WPL6; A 516 Gr. 60, 65; AA 529 Gr. 50; A 572 Gr. 42, 65; A 633 Gr. A, D, E; A 662 Gr. A, B, C; A 707 Gr. L1, L2, L3; A 738 Gr. A; A 841 A, B, C</b><br/> <b>NFA 35-207: A510PP1 – A550PP2</b><br/> <b>NFA 36208: 3.5 Ni 285 ct 355 (12N14)</b><br/>           OPTIM 500ML, PAS 65 us, PAS 70 us, Dilimax 500, Dilimax 550, Weldox 500</p> |                |                  |          |                            |                         |        |          |                         |       |           |       |     |    |    |    |     |
| AGRÉMENTS                                   | CE   |                |                  |          |                            |                         |        |          |                         |       |           |       |     |    |    |    |     |
| POSITIONS DE SOUDAGE                        |   |                |                  |          |                            |                         |        |          |                         |       |           |       |     |    |    |    |     |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Ni</th> </tr> </thead> <tbody> <tr> <td>0.05</td> <td>0.5</td> <td>1</td> <td>0.015</td> <td>0.015</td> <td>2.3</td> </tr> </tbody> </table>  | C              | Si               | Mn       | P                          | S                       | Ni     | 0.05     | 0.5                     | 1     | 0.015     | 0.015 | 2.3 |    |    |    |     |
| C   | Si   | Mn             | P                | S        | Ni                         |                         |        |          |                         |       |           |       |     |    |    |    |     |
| 0.05  | 0.5  | 1              | 0.015            | 0.015    | 2.3                        |                         |        |          |                         |       |           |       |     |    |    |    |     |
| PROPRIÉTÉS MÉCANIQUES                       | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">Rp0,2 (MPa)</th> <th rowspan="2">Rm (MPa)</th> <th rowspan="2">A5 (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>-20°C</th> <th>-80°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>530</td> <td>630</td> <td>24</td> <td>80</td> <td>60</td> <td>HRc</td> </tr> </tbody> </table>   | Heat Treatment | Rp0,2 (MPa)      | Rm (MPa) | A5 (%)                     | Impact Energy (J) ISO-V |        | Hardness | -20°C                   | -80°C | As Welded | 530   | 630 | 24 | 80 | 60 | HRc |
| Heat Treatment                              | Rp0,2 (MPa)  |                |                  |          |                            | Rm (MPa)                | A5 (%) |          | Impact Energy (J) ISO-V |       | Hardness  |       |     |    |    |    |     |
|   |  | -20°C          | -80°C            |          |                            |                         |        |          |                         |       |           |       |     |    |    |    |     |
| As Welded                                   | 530  | 630            | 24               | 80       | 60                         | HRc                     |        |          |                         |       |           |       |     |    |    |    |     |
| ETUVAGE                                     | 400°C / 1 hr   |                |                  |          |                            |                         |        |          |                         |       |           |       |     |    |    |    |     |
| GAS ACC. EN ISO 14175                       |  |                |                  |          |                            |                         |        |          |                         |       |           |       |     |    |    |    |     |



# CEWELD E 8018-C1

E 8018-C1 3,2 X 350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,6     | 8720663401298 |