



# CEWELD E 6018 LC

**TYPE** High basic extra low hydrogen electrode for stick welding.

**APPLICATIONS** Pipe work, shipbuilding, buffer layers, vessel construction, difficult metallurgical joints, mechanical engineering.

**PROPRIÉTÉS** Extremely crack resistant weld metal conditioned by the high basic slag. Low spatter loss, easy slag removal. Well suited for joining high carbon steels and when welding critical mixed base metal combinations. Ideal metallurgical choice for repair welding and production as well as for use as a buffer layer. Developed for repair welding of pipes using half shells or T split joints. Extreme low hydrogen content HD <3ml/100gr.

**CLASSIFICATION**

|        |                        |
|--------|------------------------|
| AWS    | A 5.1: E 6018          |
| EN ISO | 2560-A: E 35 4 B 32 H5 |
| F-nr   | 4                      |
| FM     | 1                      |

**CONVIENT POUR** Re ≤355 MPa (51 ksi (67 ksi) ISO 15608: 1.1, 1.2  
 S235JR-E295, S235J2G3 - S355J2G3, C22, P235T1-P275T1, P235T2, P275T2, L210 - L320, L290MB - L320MB, P235G1TH, P255G1TH, P235GH, P265GH, P295GH, S235JRS1 - S235J4S, S355G1S - S355G3S, S255N - S355N, P255NH-P355NH, S255NL - S355NL, GE200-GE240  
 ASTM: A 27 u. A36 Gr. alle; A214; A 242 Gr.1-5; A266 Gr. 1, 2, 4; A283 Gr. A, B, C, D; A285 Gr. A, B, C; A299 Gr. A, B; A328; A366; A515 Gr. 60, 65, 70; A516 Gr. 55; A570 Gr. 30, 33, 36, 40, 45; A 572 Gr. 42, 50; A606 Gr. Alle; A607 Gr. 45; A656 Gr. 50, 60; A668 Gr. A, B; A907 Gr. 30, 33, 36, 40; A841; A851 Gr. 1, 2; A935 Gr.45; A936 Gr. 50;  
 API 5 L Gr. B, X42-X52

**AGRÉMENTS** CE

**POSITIONS DE SOUDAGE**



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

| C    | Si   | Mn   | P    | S    |
|------|------|------|------|------|
| 0.02 | 0.27 | 0.42 | 0.02 | 0.01 |

**PROPRIÉTÉS MÉCANIQUES**

| Heat Treatment | Rp0,2 (MPa) | Rm (MPa) | A5 (%) | Impact Energy (J) ISO-V |  | Hardness |
|----------------|-------------|----------|--------|-------------------------|--|----------|
|                |             |          |        | -20°C                   |  |          |
| As Welded      | 400         | 520      | 25     | 200                     |  | HRc      |

**ETUVAGE** 400°C / 1 hr

**GAS ACC. EN ISO 14175**