



# CEWELD E 8018-C2

**TYPE** Basic Ni alloyed low hydrogen electrode for stick welding

**TOEPASSINGEN** Recommended for fine-grained steels used at low temperature (-60 to -80°C).Cryogenic and petrochemical industries. Stocking and distribution of liquid gas or products volatile.

**EIGENSCHAPPEN** Basic, Nickel alloyed (above 3%) electrode with excellent welding characteristics and easy slag removal. Extreme tough welding deposit with guaranteed excellent mechanical properties at low temperatures.HD < 5 ml/100

**CLASSIFICATIE**

AWS	A 5.5: E 8018-C2
EN ISO	2560-A: E 46 6 3Ni B 42 H5
F-nr	4
FM	1

**GESCHIKT VOOR**

**Reh ≤ 460 MPa ISO 15608: 1.2, 1.3, 2.1, 9.2**  
 1.5637, 1.6217, 1.6228, 1.0044-1.0982  
 10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6, S275N-S460N, S275NL-S460NL, S275M-S460M, S275ML-S460ML, P275NL1-P460NL1, P275NL2-P460NL2  
**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**  
**NFA 35-207: A510PP1 – A550PP2**  
**NFA 36208: 3.5 Ni 285 ct 355 (12N14)**

**GOEDKEURINGEN**

**LASPOSITIES**



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

C	Si	Mn	P	S	Ni
0.05	0.3	0.6	0.02	0.02	3.5

**MECHANISCHE WAARDEN**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				-60°C	-76°C	
As Welded	500	620	24	100	75	HRc

**HERDROGEN** 350°C / 2 hr

**GAS ACC. EN ISO 14175**