



CEWELD E 8018-C3

TYPE E 8018-C3 high basic welding electrode with <1% nickel for offshore requirements.

APPLICATIONS CEWELD® E 8018-C3 is a basic offshore electrode according to the latest offshore requirements for sub zero temperatures down to -60°C. She is suitable up to steel types with 460 MPa yield strength (such as S460).
In the fields of: Crane, heavy transport, platforms, vessel and lifting equipment in offshore, pipeline and applications that require NACE requirements (less than 1% Nickel).

PROPERTIES CEWELD® E 8018-C3 is 1% Ni alloyed electrode with excellent welding properties and extreme low hydrogen content below HD 4 ml/100gr weld metal.
CEWELD® E 8018-C3 is packed in the best in class multi layer vacuum pack to avoid costly and time consuming redrying of the electrodes.

CLASSIFICATION

AWS	A 5.5: E 8018-C3
EN ISO	2560-A: E 46 6 1Ni B 42 H5
F-nr	4
FM	1

SUITABLE FOR **Reh ≤ 460 MPa ISO 15608: ~1.3, ~3.1, 2.1,**
1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.1138, 1.5419, 1.8948, 1.8900, 1.8901, 1.8902, 1.8903, 1.8905, 1.8907, 1.8910, 1.8912, 1.8915, 1.8917, 1.8930, 1.8932, 1.8935, 1.8937, 1.8970, 1.8971, 1.8972
S460N, S420N, S460NL, P460N, StE 420, StE 460, TStE 380, S420NL, P460NL1, P420NH, P460NH, TStE 420, TStE 460, WStE 380, WStE 420, WStE 460, StE 385.7, StE 385.7 TM, StE 415,
ASTM A 203 Gr. D, E; A 350 Gr. LF1, LF2, LF3; A 420 Gr. WPL3, WPL6; A 516 Gr. 60, 65, 70; A 572 Gr. 42, 50, 55, 60, 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;
API 5 L X52, X60, X65, X52Q, X60Q, X65Q
Oceanfit 52, Oceanfit 60, Oceanfit 65, Oceanfit 355, Oceanfit 420, Oceanfit 460, alform plate 460M; durostat 400, 450, durostat B2

APPROVALS CE, DNV: 5Y46, Lloyds

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Ni
0.07	0.5	1.2	0.015	0.015	0.9

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-60°C		
As Welded	540	600	25	90		HRc
580°C±15°C 2h	470	570	25	50		HRc

REDRYING 400°C / 1 hr

GAS ACC. EN ISO 14175



CEWELD E 8018-C3

E 8018-C3 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	1,6	8720663401373

E 8018-C3 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,0	8720663401397

E 8018-C3 4,0 X 450MM

Packaging	KG/unit	EanCode
Can	3,5	8720663401410