



CEWELD E 8018-C1

TYPE Basic Ni alloyed low hydrogen electrode for stick welding

APPLICATIONS CEWELD® E 8018-C1 is for low temperature applications, Refrigerated ammonia tanks, Liquefied gas storage, piping and transportation, Weathering steels

PROPERTIES CEWELD® E 8018-C1 have a excellent arc stability and easy slag removal with low spatter losses. Developed for high impact strength properties at extreme sub zero temperatures. Hydrogen content is less than HD < 4 ml/100gr weldmetal.

CLASSIFICATION

AWS	A 5.5: E 8018-C1
EN ISO	2560-A: E 50 8 2Ni B 42 H5
F-nr	4
FM	1

SUITABLE FOR **ReH ≤ 500 MPa ISO 15608: 1.2 (275 < ReH < 360 MPa), 1.3 (ReH > 360 MPa < 500 MPa), 2.1 (360 < ReH < 460 MPa), 9.1 (Ni < 3 %)**
 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
 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)
 OPTIM 500ML, PAS 65 us, PAS 70 us, Dilimax 500, Dilimax 550, Weldox 500

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Ni
0.05	0.5	1	0.015	0.015	2.3

MECHANICAL PROPERTIES

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

REDRYING 400°C / 1 hr

GAS ACC. EN ISO 14175



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E 8018-C1 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,6	8720663401298