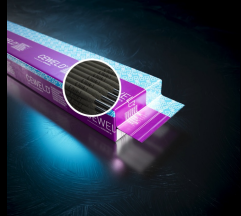


CEWELD E 7018-1

TYPE	Basic 7018-1 extra low hydrogen Stick electrode for SMAW stick welding.(E 42 4 B Type)								
APPLICATIONS	CEWELD® E 7018-1 was developed for high-quality welded joints with excellent strength and toughness properties. High strength steel constructions up to 420 MPa yield strength at -40°C applications, offshore platforms, pipe welding, shipbuilding, platforms, drills, repair welding, buffer layers on high carbon steels etc. Also suitable for welding steels with low purity and high carbon content.								
PROPERTIES	CEWELD® E 7018-1 is a low hydrogen electrode for highly stressed joints and offers remarkable weldability and high mechanical properties for steel and cast steel up to 610 MPa tensile strength and fine grain steels with increased yield strength up to 420 MPa. It is particularly suitable for welding on AC and DC+. CEWELD® E 7018-1 is suitable for steels with up to 0.6% carbon and has an extremely low hydrogen content. HD < 3 ml/100gr weld metal. CEWELD® E 7018-1 fulfills the highest requirements for moisture pickup and complies with both H4R and M designation according AWS A 5.1								
CLASSIFICATION	AWS	A 5.1: E 7018-1 H4R							
	EN ISO	2560-A: E 42 4 B 32 H5							
	F-nr	4							
	FM	1							
SUITABLE FOR	Rp< 420 MPa (60ksi) ISO 15608: 1.1 (ReH < 275 MPa), 1.2 (275 < ReH < 360 MPa), 1.3 (ReH > 360 MPa < 420 MPa) 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425,1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 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, 1.8902, 1.8912, 1.8932 10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6, S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P275NL1-P460NL1, P215NL, P265NL, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE240, A, B, D, E, A 32-E 36 ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. C, E; A 662 Gr. B; A 711 Gr. 1013; A 841 Gr. A; API 5 L Gr. B, X42, X52, X56, X60, Domex 315-420MC,MC Plus, ML								
APPROVALS	CE, DNV								
WELDING POSITIONS									
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo	V
	0.06	0.3	1.3	0.025	0.012	0.02	0.01	0.002	0.009
MECHANICAL PROPERTIES	Heat Treatment	Rp0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness		
					-40°C	-50°C			
	As Welded	450	560	26	100	80	HRc		
REDRYING	350°C / 2 hr								
CURRENT TYPE	AC, DC+								
GAS ACC. EN ISO 14175									



CEWELD E 7018-1

E 7018-1 6,0 X 450MM

Packaging	KG/unit	EanCode
Can	3,6	8720663401137

E 7018-1 2,0 X 300MM

Packaging	KG/unit	EanCode
Vacuum	1,8	8720682050637

E 7018-1 2,5 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720682050644

E 7018-1 3,2 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720682050651

E 7018-1 3,2 X 450MM

Packaging	KG/unit	EanCode
Vacuum	2,6	8720682050668

E 7018-1 4,0 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720682050675

E 7018-1 4,0 X 450MM

Packaging	KG/unit	EanCode
Vacuum	2,8	8720682050682

E 7018-1 5,0 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720682050699