



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 ≤ 380 MPa (55 ksi) ISO 15608: 1.1(ReH < 275 MPa) 1.2 (275 < ReH < 360 MPa) 1.0035, 1.0038, 1.0039, 1.0044, 1.0112, 1.0116, 1.0130, 1.0145, 1.0253, 1.0254, 1.0255, 1.0258, 1.0259, 1.0319, 1.0345, 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425, 1.0427, 1.0432, 1.0446, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.1138, 1.5419, 1.8948 C 22.8 S1, S185, S235JRG2, S235JR S235JRH, S275JR, P235S, S235J2G3, P265S, S275J2, P235TR1, P235TR2, P265TR1, P265TR2, P235GH, P235GH, P235GH, P195GH, P245GH, L245ME, GE200, P265GH, P265GH, P265GH, C 22.3, C 21 , GE240, P215NL, P255QL, P265NL, L245NE, C 22.8, P250GH, P275N, S275N, S275NL, GP240GH, P275SL, 21 Mn 6, StE 320.7, St 52.0, P280GH, (X42ME) L290ME, P305GH, P355GH, P295GH, L290NE, S355N, S355NL, P355N, P355NL1, S355J2G3, G21Mn5, G20Mo5, X52QE ASTM: A 27 u, A36 Gr. all; 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						
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	C	Si	Mn	P	S	
	0.02	0.27	0.42	0.02	0.01	
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V -20°C	Hardness
	As Welded	400	520	25	200	HRc
ETUVAGE	400°C / 1 hr					
GAS ACC. EN ISO 14175						