



CEWELD E 8018-C1

TYPE	Basic Ni alloyed low hydrogen electrode for stick welding						
ANWENDUNGEN	Low temperature applications, Refrigerated ammonia tanks, Liquefied gas storage, piping and transportation, Weathering steels						
EIGENSCHAFTEN	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.						
KLASSIFIKATION	AWS	A 5.5: E 8018-C1					
	EN ISO	2560-A: E 50 8 2Ni B 42 H5					
	F-nr	4					
	FM	1					
GEEIGNET FÜR	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						
ZULASSUNGEN	CE						
SCHWEISSPOSITIONEN	 PA  PB  PC  PD  PE  PF						
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Mn	P	S	Ni	
	0.05	0.5	1	0.015	0.015	2.3	
MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
					-20°C	-80°C	
	As Welded	530	630	24	80	60	HRc
RÜCKTROCKNUNG	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