



# 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 <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | 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 |