

## 6018 LC

<b>CATEGORY</b>	SMAW Stick Electrodes		
<b>TYPE</b>	High basic extra low hydrogen electrode for stick welding.		
<b>APPLICATIONS</b>	Pipe work, shipbuilding, bufferlayers, vessel construction, difficult metallurgical joints, mechanical engineering.		
<b>PROPERTIES</b>	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.		
<b>CLASSIFICATION</b>	AWS	A 5.1: E 6018-1 H4R	
	EN ISO	2560-A: E 35 4 B 32 H5	

<b>SUITABLE FOR</b>	Materials	EN	ASTM
	shipbuilding steels	A, B, D, AH 32 - EH 36	typical
	unalloyed structural steels	S185 - S355	A285
	boiler steels	P235GH-P355GH	A515
	pipe steels	P235T1/T2	A516
	fine grain structural steels	S255 - S355QL1	
	steels to API-standard	X 42 - X52	

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD DEPOSIT WEIGHT %**

C	Mn	Si	Cr	Ni	Mo	P	S
<0,03	0.42	0.27	-	-	-	<0.015	<0.012

**MECHANICAL PROPERTIES**

Heat Treatment	Rp0,2 (N/mm <sup>2</sup> )	Rm (N/mm <sup>2</sup> )	A5 (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW	<400	440-570	>24	>200			

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters		AC (OCV>70V) and DC+	Packing vacuum		
D (mm)	Length (mm)		Current (A)	kg	kg / 6pack
2,5	300	65-90	1.6	9.6	21
3,2	350	110-140	1.6	9.6	36
4,0	350/450	140-180	1.6	9.6	52

**REDRYING TEMPERATURE** 400°C / 1hr