

8018-C2

CATEGORY	SMAW Stick Electrodes							
TYPE	Basic Ni alloyed low hydrogen electrode for stick welding							
APPLICATIONS	Recommended for fine-grained steels used at low temperature (-60 to -80°C). Cryogenic and petrochemical industries. Stocking and distribution of liquid gas or products volatile.							
PROPERTIES	Basic, Nickel alloyed (above 3%) electrode with excellent welding characteristics and easy slag removal. Extreme tough welding deposit with guaranteed excellent mechanical properties at low temperatures. HD < 5 ml/100							
CLASSIFICATION	AWS	A 5.5: E 8018-C2 H4						
	EN ISO	2560-A:E 46 6 3Ni B 3 2 H5						
	DIN	8529: EY 4687 3Ni BH5 20						
SUITABLE FOR	Plates and tubes made out of fine grain steels, cold tough: NFA 35-207: A510PP1 – A550PP2 NFA 36208: 3.5 Ni 285 ct 355 (12N14) DIN : 10Ni14 – 14Ni6 – 16Ni14 ASTM : A203G D&E – A352GrLC3 – A334Gr3 – A350Gr LF3							
APPROVALS	CE approved							
WELDING POSITIONS:								
WELD DEPOSIT WEIGHT %	C	Mn	Si	Cr	Ni	Mo	P	S
	>0.10	0.90	0.30	-	3.5	-	<0.025	<0.025
MECHANICAL PROPERTIES								
Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRC / HV	
				-20°C	-80°C	-100°C		
AW	> 460	>550	>19		>75	>30		
AW: as welded								
WELDING PARAMETERS PACKING								
Welding Parameters				Packing				
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000			
2.5	300	80			22.1			
3.2	350	115			35			
4.0	450	150			68			
5.0	450	190			102			
REDRYING TEMPERATURE	350°C / 2hr							