




CEWELD E 10018-G

TYPE	Ultra low hydrogen high basic offshore electrode for high strength fine grain steels.										
APPLICATIONS	Designed for welding steels with tensile strength <690 MPa in offshore, crane building, heavy transport, lifting etc.										
PROPERTIES	Mn, Ni, Cr and Mo alloyed basic electrode for welding low alloyed steels with tensile strength > 620 MPa. Crack resistant and well suited for low-temperatures, ductility down to -50°C. Preheating, interpass temperature and post weld treatment as required for the base metal. Hydrogen content: < 3 ml / 100 g weld metal.										
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.1: E 10018-G</td> </tr> <tr> <td>EN ISO</td> <td>18275-A: E 62 5 1,5NiMo B 42 H5</td> </tr> <tr> <td>F-nr</td> <td>4</td> </tr> <tr> <td>FM</td> <td>2</td> </tr> </table>	AWS	A 5.1: E 10018-G	EN ISO	18275-A: E 62 5 1,5NiMo B 42 H5	F-nr	4	FM	2		
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EN ISO	18275-A: E 62 5 1,5NiMo B 42 H5										
F-nr	4										
FM	2										
SUITABLE FOR	<p>≤ 620 MPa ISO 15608: 2.2, 3.1 (360 < ReH ≤ 620 MPa) S500Q-S620Q, S500QL-S620QL, S500QL1-S620QL1, L485MB-L555MB, L485QB-L555QB, alform 500 M, 550 M, 600 M, aldur 550 Q, 550 QL, 550 QL1, Weldox 500-600, Dillimax 500-600, Naxtra ASTM A 572 Gr. 65; A 633 Gr. E; A 738 Gr. A; A 852; A 514 M Grade A, B, A 537 M, A API 5 L X70, X80, X70Q, X80Q Naxtra 63, Weldox 500, Domex 460 MC, Domex 500 MC, Domex 550 MC, Domex 600 MC, Domex 650 MC, L480 - L550, X65 - X80, Hardox 400, XAR 400, Dilidur 400,</p>										
APPROVALS	CE										
WELDING POSITIONS											
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 20%;">C</td> <td style="width: 20%;">Si</td> <td style="width: 20%;">Mn</td> <td style="width: 20%;">Ni</td> <td style="width: 20%;">Mo</td> </tr> <tr> <td>0.06</td> <td>0.6</td> <td>1.25</td> <td>1.4</td> <td>0.4</td> </tr> </table>	C	Si	Mn	Ni	Mo	0.06	0.6	1.25	1.4	0.4
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 15%;">Heat Treatment</td> <td style="width: 10%;">R_{P0,2} MPa</td> <td style="width: 10%;">R_m MPa</td> <td style="width: 10%;">A₅ (%)</td> <td style="width: 50%;">Impact Energy (J) ISO-V -50°C</td> </tr> <tr> <td>As Welded /</td> <td>690</td> <td>780</td> <td>20</td> <td>62</td> </tr> </table>	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V -50°C	As Welded /	690	780	20	62
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As Welded /	690	780	20	62							
REDRYING TEMPERATURE	400°C / 1 hr										
GAS ACCORDING EN 14175											



CEWELD E 10018-G

E 10018-G 2,5 X 300MM

Type	KG/unit	EANCode
Can	2,5	8720663416520

E 10018-G 3,2 X 350MM

Type	KG/unit	EANCode
Can	2,8	8720663416544

E 10018-G 4,0 X 450MM

Type	KG/unit	EANCode
Can	3,1	8720663416568