

# CEWELD E 6018 LC

TYPE	High basic extra low hydrogen electrode for stick welding.									
APPLICATIONS	Pipe work, shipbuilding, buffer layers, vessel construction, difficult metallurgical joints, mechanical engineering.									
PROPERTIES	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.									
CLASSIFICATION	AWS	A 5.1: E 6018								
	EN ISO	2560-A: E 35 4 B 32 H5								
	F-nr	4								
	FM	1								
SUITABLE FOR	<p>Re ≤355 MPa (51 ksi (67 ksi) ISO 15608: 1.1, 1.2            S235JR-E295, S235J2G3 - S355J2G3, C22, P235T1-P275T1, P235T2, P275T2, L210 - L320, L290MB - L320MB, P235G1TH, P255G1TH, P235GH, P265GH, P295GH, S235JRS1 - S235J4S, S355G1S - S355G3S, S255N - S355N, P255NH-P355NH, S255NL - S355NL, GE200-GE240            ASTM: A 27 u. A36 Gr. alle; A214; A 242 Gr.1-5; A266 Gr. 1, 2, 4; A283 Gr. A, B, C, D; A285 Gr. A, B, C; A299 Gr. A, B; A328; A366; A515 Gr. 60, 65, 70; A516 Gr. 55; A570 Gr. 30, 33, 36, 40, 45; A 572 Gr. 42, 50; A606 Gr. Alle; A607 Gr. 45; A656 Gr. 50, 60; A668 Gr. A, B; A907 Gr. 30, 33, 36, 40; A841; A851 Gr. 1, 2; A935 Gr.45; A936 Gr. 50;            API 5 L Gr. B, X42-X52</p>									
APPROVALS	CE									
WELDING POSITIONS	 PA  PB  PC  PD  PE  PF									
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	0.02	Si	0.27	Mn	0.42	P	0.02	S	0.01
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R <sub>P0,2</sub> MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V -20°C					
	As Welded /	400	520	25	200					
REDRYING TEMPERATURE	400°C / 1 hr									
GAS ACCORDING EN 14175										