




# CEWELD E 8018-C2

TYPE	Basic coated, Ni-alloyed stick electrode for low temperature steels. ( Type 8018-C2, E 46 6 3Ni )															
APPLICATIONS	CEWELD® E 8018-C2 is a basic coated welding electrode developed for welding all fine grain steels with up to 3.5 % Ni content at low temperatures. Mainly used in chemical, petrochemical and cryogenic plant construction, etc.															
PROPERTIES	CEWELD® E 8018-C2 is suitable for positional welding except vertical down, spatter-free welding, stable arc and X-ray safe welds. It shows excellent notched impact strength values at low temperatures and a hydrogen content HD < 5 ml/100g.															
CLASSIFICATION	AWS	A 5.5: E 8018-C2														
	EN ISO	2560-A: E 46 6 3Ni B 42 H5														
	F-nr	4														
	FM	1														
SUITABLE FOR	<b>Reh ≤ 460 MPa ISO 15608: 1.2, 1.3, 2.1, 9.2</b> 1.5637, 1.6217, 1.6228, 1.0044-1.0982 10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6, S275N-S460N, S275NL-S460NL, S275M-S460M, S275ML-S460ML, P275NL1-P460NL1, P275NL2-P460NL2 <b>ASTM A 203 Gr. D, E; A 333 Gr. 3; A334 Gr. 3; A 350 Gr. LF1, LF2, LF3; A 420 Gr. WPL3, WPL6; A 516 Gr. 60, 65; AA 529 Gr. 50; A 572 Gr. 42, 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</b> <b>NFA 35-207: A510PP1 – A550PP2</b> <b>NFA 36208: 3.5 Ni 285 ct 355 (12N14)</b>															
APPROVALS	No Approvals Found															
WELDING POSITIONS																
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 16.6%;">C</td> <td style="width: 16.6%;">Si</td> <td style="width: 16.6%;">Mn</td> <td style="width: 16.6%;">P</td> <td style="width: 16.6%;">S</td> <td style="width: 16.6%;">Ni</td> </tr> <tr> <td>0.05</td> <td>0.3</td> <td>0.6</td> <td>0.02</td> <td>0.02</td> <td>3.5</td> </tr> </table>		C	Si	Mn	P	S	Ni	0.05	0.3	0.6	0.02	0.02	3.5		
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>P0,2</sub> MPa</th> <th rowspan="2">R<sub>m</sub> MPa</th> <th rowspan="2">A<sub>5</sub> (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> </tr> <tr> <th>-60°C</th> <th>-76°C</th> </tr> <tr> <td>As Welded /</td> <td>500</td> <td>620</td> <td>24</td> <td>100</td> <td>75</td> </tr> </table>		Heat Treatment	R <sub>P0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		-60°C	-76°C	As Welded /	500	620	24	100	75
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			-60°C	-76°C												
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REDRYING TEMPERATURE	350°C / 2 hr															
GAS ACCORDING EN 14175																