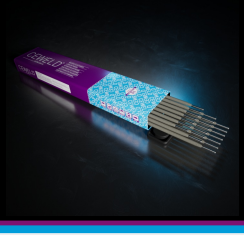


CEWELD E 12018-Mo

certilas® THE FILLER METAL SPECIALIST

TYPE

Extremely high-strength (< 890/960 MPa) basic coated offshore stick electrode with extremely low H2 content in the weld metal (Type 12018)

APPLICATIONS

CEWELD® E 12018-Mo is designed for welding heat-treatable steels with a yield strength of up to 960 MPa such as S960QL and S960V in crane construction, heavy earthmoving machinery etc. in compliance with the T8/5 time.

PROPERTIES

CEWELD® E 12018-Mo has excellent welding properties and a hydrogen content HD < 4 ml/100g in the weld metal.

CLASSIFICATION

AWS	A 5.5: E 12018-G
EN ISO	18275-A: E 89 Z B 32 H5
F-nr	4
FM	2

SUITABLE FOR

Reh < 890 Mpa Iso 15608: 3.2 (Reh > 690 MPa)
S960QL, TSTE 960V, Xabo 90, X96, Weldox 900 Weldox 1100, Domex 960, Domex Wear 360, XABO 90, StE890V, StE960TM, weldox 900, StE 890, S890QL1, A517, X120, StE 960, S960QL1, S1100 (till 12 mm)
alform plate 900 x-treme, alform plate 960 M x-treme

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo
0.063	0.42	1.41	0.88	2.33	0.75

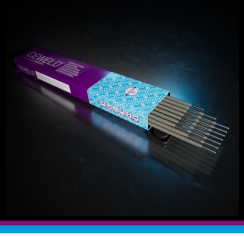
ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V -40°C
As Welded /	925	1050	17	75

REDRYING TEMPERATURE

350°C / 2 hr

GAS ACCORDING EN 14175



CEWELD E 12018-Mo

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	Type	KG/unit	EANCode
E 12018-MO 2,5 X 300MM	Vacuum	1,8	8720682050453
E 12018-MO 3,2 X 350MM	Vacuum	1,9	8720682050460
E 12018-MO 4,0 X 450MM	Vacuum	2,4	8720682050477
E 12018-MO 5,0 X 450MM	Vacuum	2,3	8720682050484