

8018-C3

CATEGORY SMAW Stick Electrodes

TYPE Ultra low hydrogen high basic offshore elektrode

APPLICATIONS Crane, heavy transport, platforms, vessel and lifting equipment in offshore, pipeline and applications that require NACE requirements (less than 1% Nickel).

PROPERTIES The basic offshore electrode according to the latest offshore requirements for sub zero temperatures down to -60°C. CTOD tested and suitable upto steel types with 460N/mm² yield strength (such as S460), approved according to grade 5Y46 at Lloyds and DNV. Excellent welding properties and extreme low hydrogen content below 3 ml/100gr weld metal. Ceweld 8018-C3 is packed in the best in class multi layer vacuum pack to avoid costly and time consuming redrying of the electrodes.

CLASSIFICATION

| | |
|--------|----------------------------|
| AWS | A 5.5: E 8018-G-H4R |
| | A 5.5: E 7018-G-H4R |
| EN ISO | 2560-A: E 50 6 1Ni B 42 H5 |
| DIN | 8529: EY 46 87Mn1NiBH5 |

SUITABLE FOR S355, S420, S460, St52, St70.2, , StE380 to StE460, 13Mn4Ni63, 15MnNi63, , 17Mn4, 19Mn5, Corten, Patinax, GS-52 to GS-60, 1.0580 to 1.0070, 1.8900 to 1.8905, 1.8930 to 1.8935, 1.8910 to 1.8915, 1.6217, 1.6210, 1.0481, 1.0482, 1.0551, 1.0553., Oceanfit 52, Oceanfit 60, Oceanfit 65, Oceanfit 355, Oceanfit 420, Oceanfit 460

APPROVALS DNV 5Y46, Lloyds 5Y46, TUV(12535.00), CE approved

WELDING POSITIONS:



WELD METAL WEIGHT %

| C | Mn | Si | Cr | Ni | Mo |
|------|-----|-----|----|-----|----|
| 0.07 | 1,3 | 0,5 | - | 0,9 | - |

MECHANICAL PROPERTIES

| Heat treatment | RP0,2 (N/mm ²) | Rm (N/mm ²) | A5 (%) | Impact energy (J) ISO-V | | | Hardness HRc / HV |
|----------------|-------------------------------|----------------------------|-----------|-------------------------|-------|------|----------------------|
| | | | | -20C | -40°C | -60C | |
| AW | >500 | 560-720 | >22 | | 120 | 90 | |
| SR | >460 | >550 | >22 | | | >47 | |

AW: as welded, SR: PWHT 580°C / 2hr

WELDING PARAMETERS / PACKING

| Welding Parameters | | | Packing | | |
|--------------------|-------------|-------------|------------------|-------------------|--------------------|
| D (mm) | Length (mm) | Current (A) | kg / vacuum pack | pcs / vacuum pack | kg / master carton |
| 2,5 | 350 | 70-90 | 0.8 | 33 | 8.0 |
| 3,2 | 350 | 110-140 | 0.7 | 18 | 7.0 |
| 4,0 | 350 | 140-180 | 0.8 | 15 | 8.0 |

REDRYING TEMPERATURE 400°C/1hr