



# CEWELD E 8018-C3

**TYPE** E 8018-C3 high basic welding electrode with <1% nickel for offshore requirements.

**APPLICATIONS** CEWELD® E 8018-C3 is a basic offshore electrode according to the latest offshore requirements for sub zero temperatures down to -60°C. She is suitable up to steel types with 460 MPa yield strength (such as S460).  
In the fields of: Crane, heavy transport, platforms, vessel and lifting equipment in offshore, pipeline and applications that require NACE requirements (less than 1% Nickel).

**PROPERTIES** CEWELD® E 8018-C3 is 1% Ni alloyed electrode with excellent welding properties and extreme low hydrogen content below HD 4 ml/100gr weld metal.  
CEWELD® E 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-C3
EN ISO	2560-A: E 46 6 1Ni B 42 H5
F-nr	4
FM	1

**SUITABLE FOR** **Reh ≤ 500 MPa ISO 15608: 1.3, ~3.1, ~2.2, 2.1,**  
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.  
S275N-S460N, S275NL-S460NL, S275M-S460M, S275ML-S460ML, P355N, P355NH, P460N, P460NH, P275NL1-P460NL1, P275NL2- P460NL2, L360NB, L415NB, L360MB-L450MB, L360QB-L450QB  
ASTM A 203 Gr. D, E; A 350 Gr. LF1, LF2, LF3; A 420 Gr. WPL3, WPL6; A 516 Gr. 60, 65, 70; A 572 Gr. 42, 50, 55, 60, 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;  
API 5 L X52, X60, X65, X52Q, X60Q, X65Q  
Oceanfit 52, Oceanfit 60, Oceanfit 65, Oceanfit 355, Oceanfit 420, Oceanfit 460, alform plate 460M; durostat 400, 450, 500, durostat B2

**APPROVALS** TÜV: (12535.00), CE, DNV: 5Y46, Lloyds

**WELDING POSITIONS**

**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	P	S	Ni
0.07	0.5	1.2	0.015	0.015	0.9

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				-60°C		
As Welded	540	600	25	90		HRc
580°C±15°C 2h	470	570	25	50		HRc

**REDRYING** 400°C / 1 hr

**GAS ACC. EN ISO 14175**



# CEWELD E 8018-C3

E 8018-C3 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	1,6	8720663401373

E 8018-C3 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,0	8720663401397

E 8018-C3 4,0 X 450MM

Packaging	KG/unit	EanCode
Can	3,5	8720663401410