



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

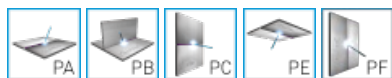
AWS	A 5.5: E 8018-C2
EN ISO	2560-A: E 46 6 3Ni B 42 H5
F-nr	4
FM	1

SUITABLE FOR

Reh ≤ 460 MPa ISO 15608: 1.2, 1.3, 2.1, 9.2
 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
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
NFA 35-207: A510PP1 – A550PP2
NFA 36208: 3.5 Ni 285 ct 355 (12N14)

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Ni
0.05	0.3	0.6	0.02	0.02	3.5

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-60°C	-76°C	
As Welded	500	620	24	100	75	HRc

REDRYING 350°C / 2 hr

GAS ACC. EN ISO 14175