



CEWELD E 6018 LC

TYPE High basic extra low hydrogen electrode for stick welding.(6018, 35 4 B

APPLICATIONS CEWELD® E 6018 LC is a extremely crack resistant weld metal conditioned by the high basic slag. Low spatter loss, easy slag removal. Well suited for joining high carbon steels and when welding critical mixed base metal combinations
Pipe work, shipbuilding, buffer layers, vessel construction, difficult metallurgical joints, mechanical engineering.

PROPERTIES CEWELD® E 6018 LC is a ideal metallurgical choice for repair welding and production as well as for use as a buffer layer. Developed for repair welding of pipes using half shells or T split joints. Extreme low hydrogen content HD <3ml/100gr.

CLASSIFICATION

AWS	A 5.1: E 6018
EN ISO	2560-A: E 35 4 B 32 H5
F-nr	4
FM	1

SUITABLE FOR Re ≤355 MPa (51 ksi (67 ksi) ISO 15608: 1.1, 1.2
S235JR-E295, S235J2G3 - S355J2G3, C22, P235T1-P275T1, P235T2, P275T2, L210 - L320, L290MB - L320MB, P235G1TH, P255G1TH, P235GH, P265GH, P295GH, S235JRS1 - S235J4S, S355G1S - S355G3S, S255N - S355N, P255NH-P355NH, S255NL - S355NL, GE200-GE240
ASTM: A 27 u. A36 Gr. alle; A214; A 242 Gr.1-5; A266 Gr. 1, 2, 4; A283 Gr. A, B, C, D; A285 Gr. A, B, C; A299 Gr. A, B; A328; A366; A515 Gr. 60, 65, 70; A516 Gr. 55; A570 Gr. 30, 33, 36, 40, 45; A 572 Gr. 42, 50; A606 Gr. Alle; A607 Gr. 45; A656 Gr. 50, 60; A668 Gr. A, B; A907 Gr. 30, 33, 36, 40; A841; A851 Gr. 1, 2; A935 Gr.45; A936 Gr. 50;
API 5 L Gr. B, X42-X52

APPROVALS CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S
0.02	0.27	0.42	0.02	0.01

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
				-20°C	
As Welded	400	520	25	200	HRc

REDRYING 400°C / 1 hr

GAS ACC. EN ISO 14175