



CEWELD E 12018-G

TYPE	Low hydrogen basic electrode for extra high strength steels	
APPLICATIONS	Designed for welding heat treated steels with yield strength upto 900 Mpa such as XABO 900, heavy lifting earth moving equipment etc.	
PROPRIÉTÉS	Basic electrode with excellent welding characteristics, recommended for welding fine grained similar alloyed high yield strength steel (< 900 Mpa) in case high impact values are required at sub zero temperatures. Hydrogen content (HD < 4 ml/100 g).	
CLASSIFICATION	AWS	A 5.5: E 12018-G
	EN ISO	18275-A: E 79 5 Mn2Ni1CrMo B 42 H5
	F-nr	4
	FM	2

CONVIENT POUR

Reh < 790 MPa Iso 15608: 3.2 (> 690(700) MPa)
 1.7147, 1.7149, 1.8734, 1.8894, 1.8914, 1.8927, 1.8931, 1.8938, 1.8951, 1.8974
 S620Q, S620QL, S690Q, S690QL, S620QL1-S690QL1, TStE 770 V, S770QL, 20MnCr65, 28CrMn4-3
 L480 - L550, X65, X80, X90, X100
 ASTM A 514 Gr. F, H, Q; A 709 Gr. 100 Type B, E, F, H, Q; A 709 Gr. HPS 100W
 Weldox 700, Dillimax 690, Hardox, Naxtra 63, Naxtra 70, Optim 700 mc plus, Weldox 500, Hardox,
 Domex 460 MC, Domex 500 MC, Domex 550 MC, Domex 600 MC, Domex 650 MC, Domex 700 MC,
 Hardox 400, Strenx 700; XAR 400, Dillidur 400, Oceanfit 100, Oceanfit 690, alform plate 620 M, 700 M,
 aldur 620 Q, 620 QL, 620 QL1, aldur 700 Q, 700 QL, 700 QL1, Salzgitter S700MC, Ympress Steel E690
 TM, S700MC, Amstrong Ultra 650MC, 650 Mct, 700 MC, HR700LA

AGRÉMENTS

POSITIONS DE SOUDAGE



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.08	0.48	1.8	0.015	0.015	0.85	2.4	0.5

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-50°C		
As Welded	840	970	18	50		HRC

ETUVAGE Not required

GAS ACC. EN ISO 14175



CEWELD E 12018-G

E 12018-G 2,5 X 300MM

Packaging	KG/unit	EanCode
Vacuum	1,7	8720682050422

E 12018-G 3,2 X 350MM

Packaging	KG/unit	EanCode
Vacuum	1,9	8720682050439

E 12018-G 4,0 X 350MM

Packaging	KG/unit	EanCode
Vacuum	1,9	8720682050446