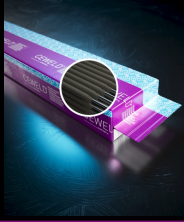


# CEWELD E 12018-Mo

|                                                        |                                                                                                                                                                                                                                                                                                                     |                            |                         |                       |                                  |          |
|--------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------|-------------------------|-----------------------|----------------------------------|----------|
| TYPE                                                   | Low hydrogen basic electrode for extreme high strenght steels                                                                                                                                                                                                                                                       |                            |                         |                       |                                  |          |
| APPLICATIONS                                           | Designed for welding heat treated steels with yield strength > 960 MPa such as S960QL and TsTE960V in crane building, heavy lifting earth moving equipment etc.                                                                                                                                                     |                            |                         |                       |                                  |          |
| PROPRIÉTÉS                                             | Basic electrode with excellent welding characteristics, recommended for welding fine grained similar alloyed high yield strength steel > 960 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 89 4 Z B 62 H5  |                         |                       |                                  |          |
|                                                        | F-nr                                                                                                                                                                                                                                                                                                                | 4                          |                         |                       |                                  |          |
|                                                        | FM                                                                                                                                                                                                                                                                                                                  | 2                          |                         |                       |                                  |          |
| CONVIENT POUR                                          | <b>Reh &lt; 890 Mpa Iso 15608: 3.2 (Reh &gt; 690 MPa)</b><br>S960QL, TSTE 960V, Xabo 90, X96, Weldom 900 Weldom 1100, Domex 960, Domex Wear 360, XABO 90, StE890V, StE960TM, weldox 900, StE 890, S890QL1, A517, X120, StE 960, S960QL1, S1100 (till 12 mm)<br>alform plate 900 x-treme, alform plate 960 M x-treme |                            |                         |                       |                                  |          |
| AGRÉMENTS                                              | CE                                                                                                                                                                                                                                                                                                                  |                            |                         |                       |                                  |          |
| POSITIONS DE SOUDAGE                                   |                                                                                                                                                                                                                                    |                            |                         |                       |                                  |          |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL DE<br>SOUDURE (%) | C                                                                                                                                                                                                                                                                                                                   | Si                         | Mn                      | Cr                    | Ni                               | Mo       |
|                                                        | 0.063                                                                                                                                                                                                                                                                                                               | 0.42                       | 1.41                    | 0.88                  | 2.33                             | 0.75     |
| PROPRIÉTÉS MÉCANIQUES                                  | Heat Treatment                                                                                                                                                                                                                                                                                                      | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A <sub>5</sub><br>(%) | Impact Energy (J) ISO-V<br>-40°C | Hardness |
|                                                        | As Welded                                                                                                                                                                                                                                                                                                           | 925                        | 1050                    | 17                    | 75                               | HRc      |
| ETUVAGE                                                | 350°C / 2 hr                                                                                                                                                                                                                                                                                                        |                            |                         |                       |                                  |          |
| CURRENT TYPE                                           | DC+                                                                                                                                                                                                                                                                                                                 |                            |                         |                       |                                  |          |
| GAS ACC. EN ISO 14175                                  |                                                                                                                                                                                                                                                                                                                     |                            |                         |                       |                                  |          |



# CEWELD E 12018-Mo

|                        |           |         |               |
|------------------------|-----------|---------|---------------|
| E 12018-MO 2,5 X 300MM | Packaging | KG/unit | EanCode       |
|                        | Vacuum    | 1,8     | 8720682050453 |
| E 12018-MO 3,2 X 350MM | Packaging | KG/unit | EanCode       |
|                        | Vacuum    | 1,9     | 8720682050460 |
| E 12018-MO 4,0 X 450MM | Packaging | KG/unit | EanCode       |
|                        | Vacuum    | 2,4     | 8720682050477 |
| E 12018-MO 5,0 X 450MM | Packaging | KG/unit | EanCode       |
|                        | Vacuum    | 2,3     | 8720682050484 |