

## 8018-C1

**CATEGORY** SMAW Stick Electrodes

**TYPE** Basic Ni alloyed low hydrogen electrode for stick welding

**APPLICATIONS** Low temperature applications, Refrigerated ammonia tanks, Liquefied gas storage, piping and transportation, Weathering steels

**PROPERTIES** Excellent arc stability and easy slag removal with low spatter losses. Developed for high impact strength properties at extreme sub zero temperatures. Hydrogen content is less than 4ml/100gr weldmetal.

**CLASSIFICATION**

AWS	A 5.5: E 8018-C1 H4R
EN ISO	2560-A: E 50 8 2 Ni B 42 H5 2560-B: ~E 57 18-3N3 A
DIN	8529: EY 50 76 2 Ni B

<b>SUITABLE FOR</b>	<b>Material:</b>	<b>DIN:</b>	<b>W.Nr:</b>
	Finegrained steels	ESTe 380 to ESTe 500	1.8911 to 1.8919
	Fine Micro alloyed steels	-	-
	Quenched and tempered	Naxtra 56	1.7279
	Low temperature steels	TTSt35N to TTSt45V	-
	-	14Ni6 to 16Ni14	1.5622 to 1.5639

**WELDING POSITIONS:**



**WELD DEPOSIT WEIGHT %**

C	Mn	Si	Cr	Ni	Mo
0.05	1.0	0.5	-	2.3	-

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-80°C	
AW	>510	590-670	>22			>55	

AW: as welded

**WELDING PARAMETERS PACKING**

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) DC+	kg / can	kg / 6pack	kg / 1000
2.5	300	70-90	1.6	9.6	19.8
3.2	350	100-140	2.0	12	36.4
4.0	450	140-180	3.5	21	66.7

**REDRYING TEMPERATURE** 400°C/1hr