

## 8018-C2

<b>CATEGORY</b>	SMAW Stick Electrodes							
<b>TYPE</b>	Basic Ni alloyed low hydrogen electrode for stick welding							
<b>APPLICATIONS</b>	Recommended for fine-grained steels used at low temperature (-60 to -80°C). Cryogenic and petrochemical industries. Stocking and distribution of liquid gas or products volatile.							
<b>PROPERTIES</b>	Basic, Nickel alloyed (above 3%) electrode with excellent welding characteristics and easy slag removal. Extreme tough welding deposit with guaranteed excellent mechanical properties at low temperatures. HD < 5 ml/100							
<b>CLASSIFICATION</b>	AWS	A 5.5: E 8018-C2 H4						
	EN ISO	2560-A:E 46 6 3Ni B 3 2 H5						
	DIN	8529: EY 4687 3Ni BH5 20						
<b>SUITABLE FOR</b>	Plates and tubes made out of fine grain steels, cold tough: <b>NFA 35-207:</b> A510PP1 - A550PP2 <b>NFA 36208:</b> 3.5 Ni 285 ct 355 (12N14) <b>DIN :</b> 10Ni14 - 14Ni6 - 16Ni14 <b>ASTM :</b> A203G D&E - A352GrLC3 - A334Gr3 - A350Gr LF3							
<b>WELDING POSITIONS:</b>								
<b>WELD DEPOSIT WEIGHT %</b>	C	Mn	Si	Cr	Ni	Mo	P	S
	>0.10	0.90	0.30	-	3.5	-	<0.025	<0.025
<b>MECHANICAL PROPERTIES</b>								
Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc / HV	
				-20°C	-80°C	-100°C		
AW	> 460	>550	>19		>75	>30		
AW: as welded								
<b>WELDING PARAMETERS PACKING</b>								
Welding Parameters				Packing				
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000			
2.5	300	80			22.1			
3.2	350	115			35			
4.0	450	150			68			
5.0	450	190			102			
<b>REDRYING TEMPERATURE</b>	350°C / 2hr							