

6018 LC

CATEGORY SMAW Stick Electrodes

TYPE High basic extra low hydrogen electrode for stick welding.

APPLICATIONS Pipe work, shipbuilding, bufferlayers, vessel construction, difficult metallurgical joints, mechanical engineering.

PROPERTIES 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. 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 6018-1 H4R
EN ISO 2560-A: E 35 4 B 32 H5

SUITABLE FOR	Materials	EN	ASTM
	shipbuilding steels	A, B, D, AH 32 - EH 36	typical
	unalloyed structural steels	S185 - S355	A285
	boiler steels	P235GH-P355GH	A515
	pipe steels	P235T1/T2	A516
fine grain structural steels	S255 - S355QL1		
steels to API-standard	X 42 - X52		

APPROVALS CE approved

WELDING POSITIONS:



WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Mo	P	S
<0,03	0.42	0.27	-	-	-	<0.015	<0.012

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW	<400	440-570	>24	>200			

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters		AC (OCV>70V) and DC+	Packing vacuum		
D (mm)	Length (mm)		Current (A)	kg	kg / 6pack
2,5	300	65-90	1.0	6.0	21
3,2	350	110-140	1.0	6.0	36
4,0	350/450	140-180	1.0	6.0	52

REDRYING TEMPERATURE 400°C / 1hr