

ES 8018-C1

SMAW

ESWECO
The Art of Welding

Type Lime-basic

E8018-C1

Description

ES 8018-C1 is a 2.5% nickel-alloyed LMA electrode suitable for the welding of low-alloy steels with impact requirements down to -60°C. The composition of the weld metal is such that good, low- temperature impact properties are obtained, even when welding vertically up. The weld metal of ES 8018-C1 is also noted for its good corrosion resistance to sea-water and sulphuric acid fumes.

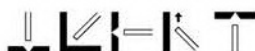
Recovery

120%

Current

AC, DC+ OCV 65 V

Welding positions



Classifications

SFA/AWS A5.5 E8018-C1
EN 499 E 46 6 2Ni B 32 H5

Typical all weld metal composition, %

C	Si	Mn	Ni
0.05	0.3	1.0	2.4

Typical mech. Properties all weld metal

Yield stress, MPa 520
Tensile strength, MPa 610
Elongation, % 26

Charpy V

Test temps, °C Impact values, J
-55 110
-59 105
-60 105

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	70-110	23
3.2	450	105-150	23
4.0	450	140-190	23
5.0	450	190-270	27