

ES 8018-C2

SMAW

E8018-C2

ESWECO
The Art of Welding

Type Basic

Description

ES 8018-C2 is excellent for low temperature applications requiring tensile strengths greater than 80,000 psi and for welding 2% to 4% nickel steels. The coating is specially formulated to reduce moisture pick-up, minimizing hydrogen cracking and starting porosity.

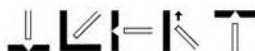
ES 8018-C2 is an excellent choice for shipbuilding, piping, and gas storage tanks.

Typical application such as crane, heavy transport, platforms, vessel and lifting equipment in offshore, pipeline.

Current

AC, DC+

Welding positions



Classifications

SFA/AWS A5.5	E8018-C2
EN 499	E 46 6 3Ni B42

Typical all weld metal composition, %

C	Si	Mn	Ni
0.06	0.3	0.6	3.3

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	170
-73	90
-95	40

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	55-85	24
3.2	350	80-140	24
4.0	450	120-180	24