

ES 8018-C3

Type Basic

SMAW

E8018-C3

ESWECO
The Art of Welding

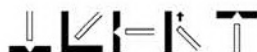
Description

High tensile, low hydrogen, iron powder electrode for welding 1% Nickel Steels subjected to low temperature service applications especially where notch toughness is required to temperature as low as -60°C.

Typical application for ES 8018-C3 is an excellent choice for shipbuilding, piping, gas storage tanks, commercial, and military applications.

Current

AC, DC+ (-)



Classifications

SFA/AWS A5.5	E8018-C3 H4R
EN 499	E 46 6 1Ni B42 H5

Typical all weld metal composition, %

C	Si	Mn	Ni
0.07	0.4	1.2	0.9

Typical mech. Properties all weld metal

Yield stress, MPa	>485
Tensile strength, MPa	>580
Elongation, %	>26

Charpy V

Test temps, °C	Impact values, J
-40	>80
-51	>60
-60	>40

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	70-110	25
3.2	350	80-150	25
4.0	450	100-190	26