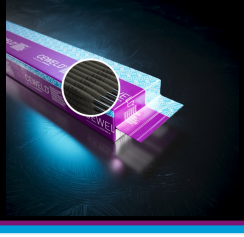


CEWELD E 7018-1

certilas® THE FILLER METAL SPECIALIST

TYPE

Basic 7018-1 extra low hydrogen Stick electrode for SMAW stick welding.(E 42 4 B Type)

APPLICATIONS

CEWELD® E 7018-1 was developed for high-quality welded joints with excellent strength and toughness properties. High strength steel constructions up to 420 MPa yield strength at -40°C applications, offshore platforms, pipe welding, shipbuilding, platforms, drills, repair welding, buffer layers on high carbon steels etc. Also suitable for welding steels with low purity and high carbon content.

PROPERTIES

CEWELD® E 7018-1 is a low hydrogen electrode for highly stressed joints and offers remarkable weldability and high mechanical properties for steel and cast steel up to 610 MPa tensile strength and fine grain steels with increased yield strength up to 420 MPa. It is particularly suitable for welding on AC and DC+. CEWELD® E 7018-1 is suitable for steels with up to 0.6% carbon and has an extremely low hydrogen content. HD < 3 ml/100gr weld metal.
CEWELD® E 7018-1 fulfills the highest requirements for moisture pickup and complies with both H4R and M designation according AWS A 5.1

CLASSIFICATION

AWS	A 5.1: E 7018-1 H4R
EN ISO	2560-A: E 42 4 B 32 H5
F-nr	4
FM	1

SUITABLE FOR

Rp< 420 MPa (60ksi) ISO 15608: 1.1 (ReH < 275 MPa), **1.2** (275 < ReH < 360 MPa), **1.3** (ReH > 360 MPa < 420 MPa)
1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425,1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932
10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6,
S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P275NL1-P460NL1, P215NL, P265NL, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE240,
A, B, D, E, A 32-E 36
ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. C, E; A 662 Gr. B; A 711 Gr. 1013; A 841 Gr. A; API 5 L Gr. B, X42, X52, X56, X60, Domex 315-420MC,MC Plus, ML

APPROVALS

CE, DNV

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo	V
0.06	0.3	1.3	0.025	0.012	0.02	0.01	0.002	0.009

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-40°C	-50°C	
As Welded	450	560	26	100	80	HRc

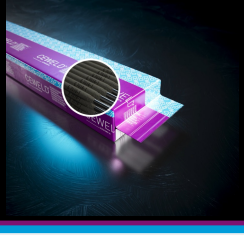
REDRYING

350°C / 2 hr

CURRENT TYPE

AC, DC+

GAS ACC. EN ISO 14175



CEWELD E 7018-1

certilas® THE FILLER METAL SPECIALIST

E 7018-1 6,0 X 450MM

Packaging	KG/unit	EanCode
Can	3,6	8720663401137

E 7018-1 2,0 X 300MM

Packaging	KG/unit	EanCode
Vacuum	1,8	8720682050637

E 7018-1 2,5 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720682050644

E 7018-1 3,2 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720682050651

E 7018-1 3,2 X 450MM

Packaging	KG/unit	EanCode
Vacuum	2,6	8720682050668

E 7018-1 4,0 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720682050675

E 7018-1 4,0 X 450MM

Packaging	KG/unit	EanCode
Vacuum	2,8	8720682050682

E 7018-1 5,0 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720682050699