

CEWELD E 9018-G

TYPE Mo-Ni-alloyed, basic coated stick electrode with high toughness and low H₂ content. (Type E9018-G, E 55 6)

APPLICATIONS CEWELD® E 9018-G is a basic coated welding electrode, very tough, has a high tensile strength and yield strength. Used for welding steel with a tensile strength between 620 and 760 MPa. Used for joining cast steel, pipes, boilers, pressure vessels and bearing frames in crane construction, heavy engineering, offshore, etc.

PROPERTIES CEWELD® E 9018-G shows a stable arc, more even welding and easy slag removal. Very good notched bar impact values down to -60°C are achieved with a yield strength of 550 MPa and a hydrogen content of HD 4 ml/100gr.

CLASSIFICATION

AWS	A 5.5: E 9018-G
EN ISO	18275-A: E 62 4 1NiMo B 42 H5
F-nr	4
FM	2

SUITABLE FOR **Reh ≤ 550 MPa, Iso 15608: 1.3, 2.1, ~3.1**
 S460N, S460M, S460NL, S460ML, S460Q-S555Q, S460QL-S550QL, S460QL1-S550QL1, P460N, P460NH, P460NL1, P460NL2, L415NB, L415MB-L555MB, L415QB-L555QB, 17MnMoV64, 15CuMoNb5, 11NiMoV53, 20MnMoNi4-5, 15NiCuMoNb5-6-4, GE300
 Oceanfit 60, Oceanfit 65, Oceanfit 420, Oceanfit 460, 4130, 4140, X80, X90, alform 500 M, 550 M, aldur 500 Q, 500 QL, 500 QL1, aldur 550 Q, 550 QL, 550 QL1
 ASTM A 572 Gr. 65; A 633 Gr. E; A 738 Gr. A; A 852; API 5 L X60, X65, X70, X80, X60Q, X65Q, X70Q, X80Q

APPROVALS CE

WELDING POSITIONS

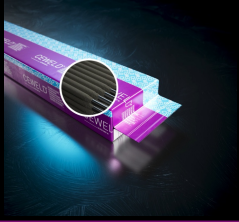


TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Ni	Mo	Fe
	0.07	0.55	1.2	0.02	0.02	1.4	0.45	Rem.

MECHANICAL PROPERTIES	Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
					RT	-40°C	
	As Welded	650	720	20	150	52	HRC

REDRYING 400°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E 9018-G

E 9018-G 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2.6	8720663424389

E 9018-G 3,2 X 450MM

Packaging	KG/unit	EanCode
Can	3,2	8720663424402

E 9018-G 4,0 X 450MM

Packaging	KG/unit	EanCode
Can	3.3	8720663424426

E 9018-G 5,0 X 450MM

Packaging	KG/unit	EanCode
Can	3.3	8720663424440