

## E 8018-C3

<b>CATEGORY</b>	SMAW Stick Electrodes																																		
<b>TYPE</b>	Ultra low hydrogen high basic offshore elektrode																																		
<b>APPLICATIONS</b>	Crane, heavy transport, platforms, vessel and lifting equipment in offshore, pipeline and applications that require NACE requirements (less than 1% Nickel).																																		
<b>PROPERTIES</b>	The basic offshore electrode according to the latest offshore requirements for sub zero temperatures down to -60°C. CTOD tested and suitable upto steel types with 460N/mm2 yield strength (such as S460), approved according to grade 5Y46 at Lloyds and DNV. Excellent welding properties and extreme low hydrogen content below 3 ml/100gr weld metal. Ceweld 8018-C3 is packed in the best in class multi layer vacuum pack to avoid costly and time consuming redrying of the electrodes.																																		
<b>CLASSIFICATION</b>	AWS	A 5.5: E 8018-G-H4R F-No. 4																																	
	EN ISO	2560-A: E 50 6 1Ni B 42 H5 FM1																																	
	DIN	8529: EY 46 87Mn1NiB5																																	
<b>SUITABLE FOR</b>	S355, S420, S460, St52, St70.2, , StE380 to StE460, 13Mn4Ni63, 15MnNi63, , 17Mn4, 19Mn5, Corten, Patinax, GS-52 to GS-60, 1.0580 to 1.0070, 1.8900 to 1.8905, 1.8930 to 1.8935, 1.8910 to 1.8915, 1.6217, 1.6210, 1.0481, 1.0482, 1.0551, 1.0553., Oceanfit 52, Oceanfit 60, Oceanfit 65, Oceanfit 355, Oceanfit 420, Oceanfit 460																																		
<b>APPROVALS</b>	DNV 5Y46, Lloyds 5Y46, TUV(12535.00), CE approved																																		
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<b>WELD METAL WEIGHT %</b>	<table border="1"> <thead> <tr> <th>C</th> <th>Mn</th> <th>Si</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.07</td> <td>1,3</td> <td>0,5</td> <td>-</td> <td>0,9</td> <td>-</td> </tr> </tbody> </table>					C	Mn	Si	Cr	Ni	Mo	0.07	1,3	0,5	-	0,9	-																		
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<b>REDRYING TEMPERATURE</b>	400°C/1hr																																		