



CEWELD E 12018-G

TYPE	Low hydrogen basic NiCrMo electrode for extra high strength steels. (E 79 5, E12018-G)
APPLICATIONS	CEWELD® E 12018-G is a basic electrode with excellent welding characteristics, recommended for welding fine grained similar alloyed high yield strength steel (< 830 MPa) Used in the heavy boiler and pressure vessels industry, highly stressed structural components, pipes, etc...
PROPERTIES	CEWELD® E 12018-G have good radiographic quality of the joints and very good impact test values at low temperatures. Hydrogen content HD < 4 ml/100g in the weld metal.

CLASSIFICATION	AWS	A 5.5: E 12018-G
	EN ISO	18275-A: E 79 5 Mn2Ni1CrMo B 42 H5
	F-nr	4
	FM	2

SUITABLE FOR	Reh < 790 MPa Iso 15608: 3.2 (> 690(700) MPa) 1.7147, 1.7149, 1.8734, 1.8894, 1.8914, 1.8927, 1.8931, 1.8938, 1.8951, 1.8974 S620Q, S620QL, S690Q, S690QL, S620QL1-S690QL1, TStE 770 V, S770QL, 20MnCr65, 28CrMn4-3 L480 - L550, X65, X80, X90, X100 ASTM A 514 Gr. F, H, Q; A 709 Gr. 100 Type B, E, F, H, Q; A 709 Gr. HPS 100W Weldox 700, Dillimax 690, Hardox, Naxtra 63, Naxtra 70, Optim 700 mc plus, Weldox 500, Hardox, Domex 460 MC, Domex 500 MC, Domex 550 MC, Domex 600 MC, Domex 650 MC, Domex 700 MC, Hardox 400, Strenx 700; XAR 400, Dillidur 400, Oceanfit 100, Oceanfit 690, alform plate 620 M, 700 M, aldur 620 Q, 620 QL, 620 QL1, aldur 700 Q, 700 QL, 700 QL1, Salzgitter S700MC, Ympress Steel E690 TM, S700MC, Armstrong Ultra 650MC, 650 Mct, 700 MC, HR700LA
--------------	--

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

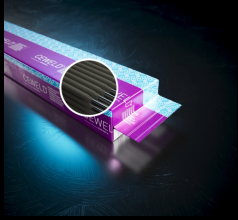
C	Si	Mn	P	S	Cr	Ni	Mo
0.08	0.48	1.8	0.015	0.015	0.85	2.4	0.5

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				-50°C	
As Welded	840	970	18	50	HRc

REDRYING	140°C / 2 hr
----------	--------------

GAS ACC. EN ISO 14175



CEWELD E 12018-G

E 12018-G 2,5 X 300MM

Packaging	KG/unit	EanCode
Vacuum	1,7	8720682050422

E 12018-G 3,2 X 350MM

Packaging	KG/unit	EanCode
Vacuum	1,9	8720682050439

E 12018-G 4,0 X 350MM

Packaging	KG/unit	EanCode
Vacuum	1,9	8720682050446