



CEWELD E 9018-G

TYPE	Ultra low hydrogen high basic offshore electrode								
ANWENDUNGEN	Crane, heavy transport, platforms, vessel and lifting equipment in offshore, pipeline, riser and applications that require NACE requirements (less than 1% Nickel).								
EIGENSCHAFTEN	High basic offshore electrode according the latest offshore requirements for sub zero temperatures down to -60°C. Suitable for steel types up to 550 MPa yield strength, excellent welding properties and extreme low hydrogen content below HD 3 ml/100gr weld metal. The weldmetal is suitable for longer post weld heat treatments as applied in Riser applications.								
KLASSIFIKATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.5: E 9018-G</td> </tr> <tr> <td>EN ISO</td> <td>18275-A: E 55 6 Mn1NiMo B 42 H5</td> </tr> <tr> <td>F-nr</td> <td>4</td> </tr> <tr> <td>FM</td> <td>2</td> </tr> </table>	AWS	A 5.5: E 9018-G	EN ISO	18275-A: E 55 6 Mn1NiMo B 42 H5	F-nr	4	FM	2
AWS	A 5.5: E 9018-G								
EN ISO	18275-A: E 55 6 Mn1NiMo B 42 H5								
F-nr	4								
FM	2								

GEEIGNET FÜR **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, 20MnMoNi45, 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

ZULASSUNGEN CE



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Ni	Mo
	0.06	0.4	1.6	0.02	0.02	1	0.3

MECHANISCHE GÜTEWERTE	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
					RT	-60°C	
	As Welded	590	680	21	150	55	HRc

RÜCKTROCKNUNG 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