

CLASSIFICATION

EN ISO 2560-A : E 42 2 Z B 42
AWS A5.1 : E8018-G

GENERAL DESCRIPTION

L-8018 is a heavily coated, Ni-Cu alloyed basic electrode. It gives a weld metal that has an excellent corrosion resistance to sea water and to flue gases. Weld metal has good mechanical properties. AS DA-708 welds with a quite, stable arc giving very little spatter.

APPROVALS

GOST, SEPRO, TSE

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Si	Mn	Ni	Cu
0.05	0.30	1.00	0.60	0.45

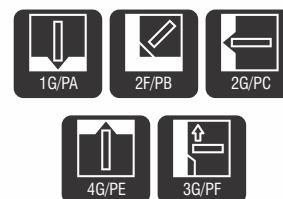
MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength	: 470 N/mm ²
Tensile Strength	: 570 N/mm ²
Elongation (L=5d)	: 28 %
Impact (ISO-V)	: 120 J (- 20°C)

WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : DC (+)

Diameter [mm]	Length [mm]	Current [A]	Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export Box Box Weight [kg]
2.50	350	80 - 115	2320	4.6 / 200	5
3.25	350	100 - 140	3700	5.0 / 135	5
4.00	450	150 - 190	7040	5.6 / 80	6



APPLICATIONS AND MATERIALS TO BE WELDED

The electrode can be used in all positions for the welding of all types of joints. L-8018 is particularly designed for welding the shell platings of ships where the protective paint coating wears severely. Ship steels of A-, D- and E- quality and slow corrosion steels (due to its copper content) of the CORTEN-A and CORTEN-B type are among other application areas. It can be used in the welding of parts that work under dynamic loads at elevated temperatures; in all construction applications including bridges, boiler and pressure vessels, and shipbuilding. L-8018 can also be used in the root pass.

	DIN	EN
General Structural Steels	St 44, St 44-2, St 44-3, St 52-3 St 50-2, St 60-2, St 70-2	S275, S355 E295, E335, E360
Fine Grained Steels	StE 255 - StE 420 WStE 255 - WStE 420 TStE 255 - TStE 420 EStE 255 - EStE 355	S255N - S420N P255NH - P420NH S255NL - S420NL / P275NL1 - P355NL1 S255NL1 - S315NL1 / P275NL2 - P355NL2
Pipe Materials	StE 210-7 - StE 360-7	L245NB - L360NB
Boiler and Pressure Vessel Steels	17 Mn 4, 19 Mn 6 H1, H11, H111	P295GH, P310GH P235GH, P265GH, P285NH
Elevated Temperature Steels	St 35-8, St 45-8	P235G1TH - P255G1TH
Ship Plates	A, D, E	-
Weather Resisting Steels	St 52-3 Cu	S355 J2G3Cu S235 J0W, S235 J2W, S355 J0W S355 J2W, S355 K2G1W

Liability : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.
Fumes : Consult information on Welding Safety Sheet, available upon request.