



# CEWELD E 9018-G

**TYPE** Mo-Ni-alloyed, basic coated stick electrode with high toughness and low H<sub>2</sub> 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 <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | 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 |