

## E 11018-H

**CATEGORY** SMAW Stick Electrodes

**TYPE** Ultra low hydrogen high basic offshore electrode for high strength fine grain steels.

**APPLICATIONS** Designed for welding steels with high yield strength >690N/mm<sup>2</sup> in offshore, crane building, heavy transport, lifting etc.

**PROPERTIES** Mn, Ni, Cr and Mo alloyed basic electrode for welding low alloyed steels with yield strength >690 N/mm<sup>2</sup>. Crack resistant and well suited for low-temperatures, ductility down to -60°C. Preheating, interpass temperature and post weld treatment as required for the base metal. **Hydrogen content:** < 3 ml / 100 g weld metal. CEWELD E 11018-H is packed in the best in class multi layer vacuum pack to avoid costly and time consuming redrying of the electrodes.

**CLASSIFICATION**

AWS	A 5.5: E 11018-M-H4
EN ISO	18275-A: E 69 6 Mn2NiCrMo B 42 H5
DIN	8529: EY 69 77 Mn2NiMo B H5

**SUITABLE FOR** Weldox 700, naxtra 70, S690, dilimax, S690QL1, S620, S550, Hardox, S620QI1, S690QL1, S600MC, S700MC, Naxtra 63, Naxtra 70, Optim 700 mc plus, TStE620, TStE690, Weldox 500, Hardox, Domex 460 MC, Domex 500 MC, Domex 550 MC, Domex 600 MC, Domex 650 MC, Domex 700 MC, L480 - L550, X65 - X80, Hardox 400, XAR 400, Dilidur 400, 20MnCr65, 28CrMn43.

**APPROVALS** DNV 5Y69, Lloyds 5Y69, CR, CE approved

**WELDING POSITIONS:**



**WELD DEPOSIT WEIGHT %**

C	Mn	Si	Cr	Ni	P	S	Mo	V
0,045-0,075	1,40-1,60	0,30-0,45	0,30-0,40	1,90-2,20	<0.025	<0.025	0,30-0,40	<0,25

**MECHANICAL PROPERTIES**

Heat treatment	R <sub>P0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	>690	>770	>17	>110	>80	>69	
SR	>690	>770	>19		>32		

AW: as welded / SR: stress relieved (PWHT) 580°C/2hr

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / vacuum pack	pcs / vacuum pack	kg / master carton
2,5	350	70-90	0,8	33	8,0
3,2	350	90-125	0,7	18	7,0
4,0	350	120-160	0,8	14	8,0

**REDRYING TEMPERATURE** 400°C/1 hr