

ZULFI E8018-C1 H4R

CLASSIFICATION

AWS A5.5 E 8018-C1 H4R

APPROVALS

ABS
BV
DNV

GRADE

PROPERTIES

Electrode for producing crack free tough welded joints. Gives weld of X-ray quality. Weld metal gives good impact values up to -60°C due to high metallurgical purity and low hydrogen content. Well suited for positional welding.

Re-baking: 350°C for 2 hours.

APPLICATIONS

ZULFI E8018-C1 is designed for use in the welding of nickel bearing steels for low temperature applications where toughness of the weld metal is important. Such applications include shipbuilding, storage, piping, and tanks used in the storage of gases.

CHEMICAL ANALYSIS [TYPICAL VALUES IN %]

C	Mn	Si	Ni
0.06	1.10	0.40	2.30

CURRENT CONDITION & WELDING POSITION

AC, DC+
All Position, Except V-down

ALL-WELD METAL MECHANICAL PROPERTIES

HEAT TREATMENT	YIELD STRENGTH (MPa)	TENSILE STRENGTH (MPa)	ELONGATION %	IMPACT STRENGTH
As Welded	> 490	> 550	> 24	60J at -60 °C

PACKING DATA

DIAMETER (MM)	LENGTH (MM)	CURRENT (A)	WEIGHT PER PACKET (KG)	NO. OF PACKETS PER CARTON
2.6	350	70-100	2.5	8
3.2	400 / 450	90-140	5.0	4
4.0	400 / 450	140-190	5.0	4
5.0	400 / 450	190-250	5.0	4