

Product: **SPARKWELD – E 8018-C3**

Classification: AWS/ASME SFA-5.5 E 8018-C3
EN ISO 3580-A E CrNi 1 B 20

Application/Properties: Electrode for welding of 1% Nickel steel and for high impact strength upto -60° c. Preheating, interpass temperature and post weld heat treatment should be in accordance with the base metal to be welded.

**Sizes and Currents
AC or DC+**

Diameter	Length	Current (A)
2.6mm	350mm	70 – 100
3.2mm	450mm	90 – 140
4.0mm	450mm	140 – 190
5.0mm	450mm	190 - 250

Weld metal analysis:

C	Si	Mn	Ni	Mo	P	S
0.06	0.24	1.10	1.00	0.20	0.011	0.011

**Mechanical
properties
of all weld
metal:**

Yield Strength	> 490 N/mm ²
Tensile Strength	560 - 690 N/mm ²
Elongation L.=5D.	> 26%
Impact Strength	>120 J at +20°C >60 J at -60°C

Packaging:

2.6mm	8x2.5kg.packet/carton
3.2 mm	4x5.0 kg. packet/carton
4.0 mm	4x5.0 kg. packet/carton
5.0 mm	4x5.0 kg. packet/carton
	1 MT/pallet