



CEWELD E 12018-Mo

TYPE Extremely high-strength (< 890/960 MPa) basic coated offshore stick electrode with extremely low H2 content in the weld metal (Type 12018)

APPLICATIONS CEWELD® E 12018-Mo is designed for welding heat-treatable steels with a yield strength of up to 960 MPa such as S960QL and S960V in crane construction, heavy earthmoving machinery etc. in compliance with the T8/5 time.

PROPERTIES CEWELD® E 12018-Mo has excellent welding properties and a hydrogen content HD < 4 ml/100g in the weld metal.

CLASSIFICATION

| | |
|--------|-------------------------|
| AWS | A 5.5: E 12018-G |
| EN ISO | 18275-A: E 89 Z B 32 H5 |
| F-nr | 4 |
| FM | 2 |

SUITABLE FOR **Reh < 890 Mpa Iso 15608: 3.2 (Reh > 690 MPa)**
 S960QL, TSTE 960V, Xabo 90, X96, Weldox 900 Weldox 1100, Domex 960, Domex Wear 360, XABO 90, StE890V, StE960TM, weldox 900, StE 890, S890QL1, A517, X120, StE 960, S960QL1, S1100 (till 12 mm)
 alform plate 900 x-treme, alform plate 960 M x-treme

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Si | Mn | Cr | Ni | Mo |
|-------|------|------|------|------|------|
| 0.063 | 0.42 | 1.41 | 0.88 | 2.33 | 0.75 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{P0.2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|----------|
| | | | | -40°C | |
| As Welded | 925 | 1050 | 17 | 75 | HRc |

REDRYING 350°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E 12018-Mo

| | | | |
|------------------------|-----------|---------|---------------|
| E 12018-MO 2,5 X 300MM | Packaging | KG/unit | EanCode |
| | Vacuum | 1,8 | 8720682050453 |
| E 12018-MO 3,2 X 350MM | Packaging | KG/unit | EanCode |
| | Vacuum | 1,9 | 8720682050460 |
| E 12018-MO 4,0 X 450MM | Packaging | KG/unit | EanCode |
| | Vacuum | 2,4 | 8720682050477 |
| E 12018-MO 5,0 X 450MM | Packaging | KG/unit | EanCode |
| | Vacuum | 2,3 | 8720682050484 |