

8018-C2 FOR (C.A.C.C.) ARC

SPECIAL WELDING ROD WITH A LOW HYDROGEN CONTENT AND POWDER IRON COVERING. ITS FILLER METAL IS A LOW NICKEL ALLOY WITH HIGH MECHANICAL RESISTANCE.

CLASSIFICATION A.W.S: E 8018C2

IDENTIFICATION: GREY COATING

APPLICATIONS: It is recommended for the production and maintenance of pressure vessels, cast parts and low temperature pipes (as low as 60°C) and to weld low alloy steel with a nickel content of 3.35%. 8018C2 welding rods have been used with excellent results with the following kinds of steel (ASTM specifications).

A 204 - 74a Gr. D and E 00000A203-61

A 352-74a Gr. LC3 0000000 A 320-65 Gr. L9 L10

A 410 - 72 0000000000000000 A 333-64 Gr. 3 and 5

A 334-74 Gr.3 000000000000 A 470-64 Gr. B, C and D

A 350-74 Gr. LF3 000000000A 471-64 Gr. 1,2 and 3

CHARACTERISTICS AND PROCEDURE: This welding rod can be used in all positions except when welding vertically downwards. Its filler metal has a nice appearance and it has neither cavities nor causes splatter. Clean the joint area to remove dirt, scales, grease and rust. Keep the arc short and slightly tilted in the same direction as the weld. Swinging while welding should not triple the core diameter. When using DC, connect the electrode holder to the positive pole (reverse polarity). Remove the slag between one pass and the next.

Precaution: Electrodes with a low hydrogen content covering are hygroscopic (they tend to absorb and retain the water from the surrounding air) so they should be kept in a dry, hot place.

TENSILE RESISTANCE:	5,940 - 6,608 KG./CM2 (84,500 A 94,000 PSI)
ELASTIC LIMIT:	5,012 - 5,835 KG./CM2 (71,300 A 83,000 PSI)
ELONGATION IN 5 cm:	25%
CHARPY V:	2.7 KG X M (-73° C)
BRINELL HARDNESS:	195 BHN
POSITIONS:	ALL EXCEPT WHEN WELDING VERTICALLY DOWNWARDS
CURRENT:	AC or DC REVERSE POLARITY

FILLER METAL CHEMICAL ANALYSIS %				SIZES	AMPERAGE
C	Mn	Si	Ni	3.25 mm - 1/8"	100-130
0.05	1.10	0.37	3.30	4.0 mm - 5/32"	140-180
				5.0 mm - 3/16"	200-250