

Excalibur® 8018-C1 MR

Key Features

- Designed to produce a 2.25% Ni deposit
- Moisture resistant basic coating
- Premium arc performance
- Easy strike and restrike, square coating burn-off

Typical Applications

- Low temperature steels such as A333 Gr6, A350 Gr LF2
- Suitable for welding of weathering steels grades
- Suitable for stress relieved applications
- Liquefied gas storage piping and transportation

Conformances

AWS A5.5/A5.5M: E8018-C1 H4R

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.4	350	ED030876	Easy Open Can 22.7kg
3.2	350	ED030877	

Mechanical Properties - As required per AWS A5.5

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -60°C
Requirements - AWS	460 min	550 min	19 min	27
Typical Results - Stress Relieved	460-525	565-615	24-32	79-129

Deposit Composition

	%C	%Mn	%Si	%P	%S
Typical Results - As Welded	0.07	1.10	0.42	0.01	0.01
	%Ni	%Cr	%Mo	%V	Diffusible Hydrogen
Typical Results - As Welded	2.45	<0.02	<0.02	<0.01	1-3 ml / 100 g

Typical Operation Procedures

Polarity	Current (amps)	
	2.4mm	3.2mm
AC / DC±	70-120	90-160