

Excaltbur® 8018-C3MR

Key Features

- Designed to produce a 1% nickel deposit
- Premium arc performance
- Square coating burn-off
- Easy strike and re-strike
- Effortless slag removal

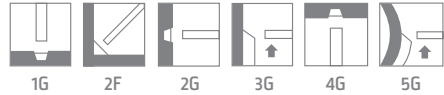
Typical Applications

- Shipbuilding
- Piping and gas storage tanks
- Weathering steels
- Cross country pipe repair

Conformances

AWS A5.5/A5.5M:	E8018-C3 H4R
ABS:	E8018-C3 H4R
CWB/CSA W48-06:	E5518-C3

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.4	350	ED032599	Easy Open Can 4.54 kg (3 X EOC per Carton)
3.2	350	ED032600	Easy Open Can 4.54 kg (3 X EOC per Carton)
4.0	350	ED030894	Easy Open Can 22.7kg

Mechanical Properties - As required per AWS A5.5/A5.5M: 2006

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -40°C
Requirements - AWS	470-550 min	550 min	24 min	27
Typical Results	505-590 min	550-675 min	24-32 min	81-163

Deposit Composition

	%C	%Mn	%Si	%P	%S
Typical Results - As Welded	0.07	1.25	0.46	<0.01	0.09
	%Ni	%Cr	%Mo	%V	Diffusible Hydrogen
Typical Results - As Welded	1.09	0.06	0.27	0.01	1-2 ml / 100 g

Typical Operation Procedures

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