

EASYARC® 8018-C3/C3H4R

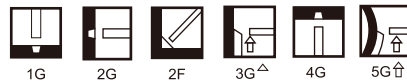
PRODUCT INFORMATION

EASYARC® 8018-C3 is a stick electrode with low hydrogen potassium based coating. This series electrode contain 1% Ni in the all-welding- metal, have robust impact properties at -40 °C. It is suitable for welding in application with high requirement for temperature impact toughness and crack resistance, such as welding of bridge, ship, offshore, low temperature pressure vessel, pipeline and so on.

CONFORMANCE

- EASYARC® 8018-C3: AWS A5.5 E8018-C3
- EASYARC® 8018-C3H4R: AWS A5.5 E8018-C3H4R

WELDING POSITIONS



TYPICAL APPLICATIONS

- Bridge
- Ship
- Offshore
- Low temperature pressure vessel
- Pipeline

TOP FEATURES

EASYARC® 8018-C3 series: The excellent operating performance, stable arc, self-peeling slag, 1%Ni composition in all weld metal, excellent impact toughness at low temperature, excellent crack resistance.

EASYARC® 8018-C3H4R: Use unique PERMAPACK® package. The electrodes using this package can be welded directly after opening package and are free of baking for 8 hours after opening package.

DIAMETERS / PACKAGING

	Diameter x Length(mm x mm)	Weight /Packet (KG)	Weight / Carton (KG)
EASYARC® 8018-C3	2.5 x 350	5	20
	3.2 x 350	5	20
	4.0 x 400	5	20
	5.0 x 400	5	20
	Diameter x Length(mm x mm)	Weight /Packet (KG)	Weight / Carton (KG)
EASYARC® 8018-C3H4R	2.5 x 350	2.5	20
	3.2 x 350	2.5	20
	4.0 x 400	2.5	20
	5.0 x 400	2.5	20

MECHANICAL PROPERTIES

Electrode	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact Value (J) -40 °C
AWS 5.5 E8018-C3/-C3H4R Requirement	min 470	min 550	24	≥27
Typical Values	495	585	29	110

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CHEMICAL COMPOSITION

PRODUCTS	C%	Mn%	S%	P%	Si%	Cr%	Ni%	Mo%	Diffusible Hydrogen (mL/100g)
Requirements AWS 5.5 E8018-C3/-C3H4R	≤0.12	0.4-1.25	≤0.03	≤0.03	≤0.8	≤0.15	0.8-1.10	≤0.35	4.0max
E8018-C3 Typical Values (%)	0.054	1.241	0.013	0.028	0.464	0.064	1.097	0.221	--
E8018-C3H4R Typical Values (%)	0.054	1.241	0.013	0.028	0.464	0.064	1.097	0.221	2.90

TYPICAL OPERATING PROCEDURES

		2.5x350	3.2x350	4.0x400	5.0x400
Current (A)	2F	70	85	160	190
Current (A)	3F	85	120	160	190

Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

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Subject to change - This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com.cn for any updated information.

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