

# Inweld 8018-C1

AWS A5.5 E8018-C1

## Chemical Composition of Inweld 8018-C1

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
Balance	0.12	---	2.00- 2.75	---	1.25	0.80	0.03	0.03	---	---

Single values are maximum unless otherwise specified.

## Description and Applications

Low Alloy, Low Hydrogen, Iron Powder electrode for welding 2% Nickel Steels where excellent sub-zero low temperature impact properties are required. Special flux coating formulated to resist moisture absorption under hot and humid weather conditions. Vacuum Sealed packaging offers further protection. Stable arc in flat/horizontal and all other positions (except vertical down), fine bead appearance free from undercuts and with excellent mechanical properties under extreme cold conditions. For welding alloys subjected to low temperatures such as those found in the production of liquid ammonia, propane, and other gases.

## Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	80,000 psi
Yield Strength:	67,000 psi
Elongation:	19%

## Recommended Parameters

SMAW (DCEP – Electrode+)

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
3/32"		70-110
1/8"		90-160
5/32"		130-210
3/16"		180-300
7/32"		250-330

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