

# Inweld 8018-C3

AWS A5.5 E8018-C3

## Chemical Composition of Inweld 8018-C3

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
Balance	0.12	0.15	0.80- 1.10	0.35	0.40- 1.25	0.80	0.03	0.03	---	---

Single values are maximum unless otherwise specified.

## Description and Applications

All-Position, high tensile, low hydrogen, iron powder electrode for welding 1% Nickel Steels subjected to low temperature service applications. For welding low nickel steels in the 70,000 - 80,000 psi tensile range where excellent sub-zero temperature impact properties are required. Excellent notch toughness at temperatures as low as -60°F. Stable arc with excellent deposition efficiency. Typical applications include Cor-Ten, Mayari R, LT75, N-A-Z High Tensile, V-55, Yoloy HS, quenched and tempered steels such as ASTM A514 and A517. Charpy Impact V: 44 ft-lbs @ -49°F.

## Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	80,000 psi
Yield Strength:	65,000 psi
Elongation:	24%

## 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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