



DESCRIPTION

Basic coated electrode with 2,5% Ni

Electrode designed for welding low-alloy fine grain steels and nickel steels with impact requirements down to -75°C. Suitable for the construction of cryogenic plant and pipework in petrochemical industry and for general low temperature applications. Its basic coating ensures excellent positional welding characteristics with good gap bridging ability. The weld pool and slag are easy to control and facilitate the achievement of a clean bead surface even in narrow preparations and in root pass.

SPECIFICATIONS

ISO 2560-A	E 46 6 2Ni B 42 H5	AWS A5.5	E8018-C1
DIN	-	Werkstoff Number	-
Certifications	-	Shielding	-
Positions	PA, PB, PC, PD, PE, PF	Current	DC+, AC

ASME QUALIFICATIONS

F-No (QW432)	4
A-No (QW442)	10

FERRITE

F-No (QW432)	-
A-No (QW442)	-

PREN

F-No (QW432)	-
A-No (QW442)	-

HARDNESS

F-No (QW432)	-
A-No (QW442)	-

CHEM. COMP. %

DEFAULT

C	0.06
Mn	1.1
Ni	2.2
P	0.01
S	0.01
Mo	0.05
Si	0.6
Cu	0.1

MECHANICAL PROPERTIES

	MIN	VARIANT
Tensile strength R _m MPa	550	630
Yield strength R _{p0.2} MPa	460	460
Elongation A (L ₀ =5d ₀) %	19	20
Impact Charpy ISO-V	27J @ -75°C	47J @ -75°C
Impact Charpy ISO-V	-	-

WELDING PARAMETERS

	2.5 mm	3.2 mm	4 mm	
Ampere	65A - 95A	100A - 140A	130A - 190A	180A -
Voltage	-	-	-	-
Packaging	45 pcs/kg	21 pcs/kg	14 pcs/kg	10 pcs/kg
Packaging Type	Carton box	Carton box	Carton box	Carton box





2Ni

DESCRIPTION

CRYOGENIC STEELS

2Ni

APPLICATION

Ideal for fabricating storage tanks, process plants, and associated pipework, especially in scenarios demanding good fracture toughness from as-welded joints, even in temperatures as low as -60°C . The addition of approximately 2.5% Ni enhances microstructural refinement and procedural tolerance compared to plain CMn weld metal. It also supports the formation of a stable patina, meeting the characteristics of weathering steels, offering an alternative to using matching consumables. Preheating should align with the base material and its thickness. While AWS consumable specifications may recommend PWHT, many fabrications may be left as-welded, with the necessity for PWHT generally determined by applicable design codes.

ALLOY TYPE

Nominally 2,5%Ni low alloy steels.

MICROSTRUCTURE

In the as-welded condition the microstructure is ferritic with a component of acicular ferrite for optimum toughness.

MATERIALS

Low temperature applications, fine-grained steels that contain up to 2.5% Nickel.

ASTM: A203 gr. A & B plate, A333 gr. 6 pipe, A350 gr. LF1 & LF2 forgings, A352 gr. LC2 casting.

API: 5L X52, 5L X56, 5L X60, 5L X65.

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The information in this datasheet is the result of detailed research and is considered accurate as of the publication date. However, we cannot guarantee its complete accuracy, and it is subject to change without notice. Actual results may vary due to many factors like welding procedures, material composition, temperature conditions, bevel configuration, and specific manufacturing techniques. We accept no liability for any errors or omissions in this datasheet. For the most current information, please visit www.daikowelding.com.

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