

**Stick electrode for 1-1.25%Cr-0.5%Mo steel**

**Features:** Applied for ASTM A387 Gr.11, Gr.12 and equivalents

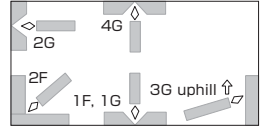
**Welding Positions:**

**Classification:** AWS A5.5 E8018-B2

**Redrying Conditions:** 325~375°Cx1h

**Identification color:** 1st Black, 2nd Yellowish green

**Polarity:** AC, DCEP

**Packaging data**

$\phi$ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	19	170W, 120H, 330L
3.2	400	5	20	38	170W, 120H, 430L
4.0	450	5	20	69	170W, 120H, 480L
5.0	450	5	20	106	170W, 120H, 480L
6.0	450	5	20	154	170W, 120H, 480L

**Composition (all-weld metal mass%)**

	Typical (AC)	Guaranty <sup>a</sup>
<b>C</b>	0.07	0.05~0.12
<b>Si</b>	0.73	0.80
<b>Mn</b>	0.78	0.90
<b>P</b>	0.01	0.03
<b>S</b>	<0.01	0.03
<b>Cr</b>	1.31	1.00~1.50
<b>Mo</b>	0.54	0.40~0.65

Note: <sup>a</sup> Single values are maximum.

**Welding parameters (A)**

$\phi$ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	65~95	60~90
3.2	90~130	80~120
4.0	135~185	110~170
5.0	190~250	-
6.0	250~320	-

**All-weld mechanical properties**

	Typical (AC)	Guaranty
<b>0.2%YS (MPa)</b>	590	462min.
<b>TS (MPa)</b>	690	552min.
<b>EI on 4d (%)</b>	26	19min.
<b>IV 0°C (J)</b>	66	-
<b>PWHT (°C/h)</b>	690x1	690±15x1

**Approvals**

LR	MG (E8018-B2)
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