

8018-B2

CATEGORY SMAW Stick Electrodes

TYPE Cr and Mo-alloyed basic low hydrogen coated electrode

APPLICATIONS Steam plants, vessel, waste plants, cementation steels, boiler works, tubes, heat exchangers

PROPERTIES Basic electrode for welding of steam production plants, steam pipes and similar joints made of Cr-Mo alloyed steel. The weld metal is resistant to working temperatures up to 550°C. as for similarly alloyed steels, quenched and tempered for cementation and nitrating. Hydrogen content: < 5 ml / 100 g weld metal

CLASSIFICATION

AWS	A 5.5: E 8018-B2
EN ISO	3580-A: E CrMo1 B 42 H5 3580-B: ~E 55 18-1CM H5
DIN	8575: E CrMo1 B 20+

SUITABLE FOR 13CrMo44, 15CrMo3, 13CrMoV42, 15Cr3, 16MnCr5, 20MnCr5, 15CrMo5, 25CrMo4, GS-22CrMo5, GS-22CrMo54, 1.7335, 1.7015, 1.7131, 1.7147, 1.7262, 1.7218,. 1.7354

APPROVALS CE approved



C	Mn	Si	Cr	Ni	Mo
0.06	0.95	0.60	1.10	-	0.50

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				20°C	-40°C	-60°C	
AW	>470	570-670	>20	>95			

AW: as welded

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) DC+	kg / can	kg / 6pack	kg / 1000
2.5	300	65-95	2.5	15	19.8
3.2	350	100-130	2.8	16.8	36.4
4.0	350	140-180	2.8	16.8	66.7
5.0	450	180-230			101.9

REDRYING TEMPERATURE 400°C/1hr

HEAT TREATMENT Stress relieved: 680°C / 2hr, oven cooling down to 300°C and then cooled on the air