

## 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 <sub>p0.2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	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