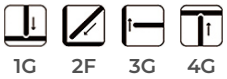
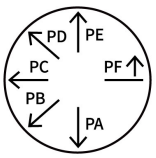
S-8018.B2

Classification

AWS A5.5/ASME SFA-5.5 E8018-B2
JIS Z 3223 E5518-1CM
EN ISO 3580-A E CrMo1 B 3 2

Welding Positions





Features

- Iron powder and low hydrogen type electrode (high efficiency)
- Good mechanical properties
- Good creep resistantance

Polarity

AC, DC ±

Application Areas

- Low alloy steel (1.25% Cr-0.5% Mo)
- Pressure vessels
- Power plants

Redrying Conditions

300~350°C (572~662°F) X 0.5~1hr

Approvals

ABS
✓

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S	Cr	Mo
0.07	0.29	0.61	0.012	0.006	1.21	0.53

Typical Mechanical Properties of All-Weld Metal

PWHT	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)
690°C*1hr	588(85)	681(99)	27

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.6 (3/32)	350 (14)	55~90	50~80	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
3.2 (1/8)	350 (14)	90~130	80~120	
4.0 (5/32)	400 (16)	130~190	120~170	
5.0 (3/16)	400 (16)	190~240	-	
6.0 (15/64)	450 (18)	250~300	-	