

OK 76.26

Type Lime basic

SMAW

E9018-B3

Description

Basic low-hydrogen electrode for the AC/DC welding of creep-resistant steels of the 2.3% Cr/1% Mo type, such as SA - 387 Grade 22/A 335 Grade P22 or similar. The weld metal has the extra-low impurity levels specified in step-cooling requirements.

Recovery

110 %

Welding current

AC, DC+ OCV 65 V



Classifications

SFA/AWS A5.5	E9018-B3
EN 1599	E CrMo2 B 42 H5

Typical all weld metal composition, %

C	Si	Mn	Cr	Mo
0.08	0.3	0.7	2.3	1.1

Typical mech. properties all weld metal

Yield stress, MPa	650
Tensile strength, MPa	740
Elongation, %	18

Charpy V

Test temps, °C	Impact values, J
-20	60

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
3.2	350	90-130	23	0.60	49	1.11	66
4.0	450	130-190	25	0.61	23	1.90	83
5.0	450	150-260	27	0.62	15	2.60	92

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