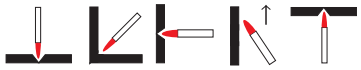
KE8018-B2

Classifications:
AWS A5.5 E8018-B2
A5.5M E5518-B2
EN E CrMo 1 B 32 H5
ISO 3580 B-E5518-1CM

Characteristics and Applications:

KE8018-B2 is an iron powder low hydrogen type stick electrode for the use of low alloy heat-resistant steel. The normal weld metal chemical compositions are 1.25%Cr -0.5%Mo. It is suitable for the welding of drawing steels(A387-Gr.11) casting steels(A217-WC6) and piping steel(A335-P11).

Welding Position:



Typical Chemical Composition of All-Weld Metal:

Alloy wt%	C	Mn	Si	Cr	Mo	P	S
AWS	0.05-0.12	0.90	0.80	1.00-1.50	0.40-0.65	0.03	0.03
Tested	0.072	0.70	0.46	1.29	0.56	0.013	0.009

Mechanical Properties of All-Weld Metal:

Mechanical properties	Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)	Impace Value (J/℃)
AWS	460	550	19	-
Tested	545	628	28	175/R T

Notes on Usage:

1. Dry the stick electrodes at 350-400°C for one hour before welding.
2. To relieve stress, PWHT at 675-705°C.
3. Preheat treatment before welding at 160-220°C and try to keep low hydrogen situation during whole welding process.
4. Keep short arc length when welding.
5. Because of excessive heat input, the impact value tends to be lower. Therefore, choose proper heat input is very important.
6. Current type : DC or AC.

Sizes Available and Recommended Parameter:

Dia/mm		3.2x350	4.0x400	5.0x400
Amp	F	90-140	140-190	190-240
	OH, V	80-120	120-160	–

eco weld

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