

ES 8018-B2L

SMAW

ESWECO
The Art of Welding

Type Lime-basic

E8018-B2L

Description

ES 8018-B2L is an outstanding welding electrode for higher strength steels with tensile strengths greater than 80,000 psi. The coating is specially formulated to resist moisture pick-up under conditions of high heat and humidity. The electrode offers resistance to moisture reabsorption, which helps prevent hydrogen cracking and aids in eliminating starting porosity.

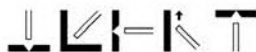
ES 8018-B2L is an excellent choice for boiler fabrication and maintenance of pressure piping such as found in steam power generating equipment, petrochemical pressure vessels, and chemical processing equipment and also in the shipbuilding industries.

Recovery

115%

Current

DC+, AC



Classifications

SFA/AWS A5.5

E8018-B2L-H4R

Typical all weld metal composition, %

C	Si	Mn	Cr	Mo
0.03	0.56	0.63	1.48	0.53

Typical mech. Properties all weld metal

Yield stress, MPa	510
Tensile strength, MPa	612
Elongation, %	28

Charpy V

Test temps, °C	Impact values, J
-20	58

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	80-110	23
3.2	350	100-140	23
4.0	450	130-190	22
5.0	450	150-260	27