

ES 8018-B2

SMAW

ESWECO
The Art of Welding

Type Lime-basic

E8018-B2

Description

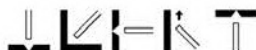
Basic, low-hydrogen electrode for the DC welding of creep-resistant steels of the 1.25% Cr, 0.5% Mo type, such as SA-387 Grade 11/A 335 P11. The weld metal has an extra-low impurity level.

Recovery

115%

Current

DC, AC



Classifications

SFA/AWS A5.5 E8018-B2-H4R
EN 1599 E Cr Mo 1 B 42 H5

Typical all weld metal composition, %

C	Si	Mn	Cr	Mo
0.07	0.4	0.6	1.4	0.6

Typical mech. Properties all weld metal

Yield stress, MPa >480
Tensile strength, MPa >580
Elongation, % 23

Charpy V

Test temps, °C Impact values, J
-30 47

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