

S-9018.B3

Type : Basic

Conformances

AWS A5.5/ ASME SFA5.5 E9018-B3
 JIS Z3223 E6218-2C1M
 EN 1599 - ECrMo2 B 3 2
 KR AWS A5.5 E9018-B3
 ABS AWS A5.5 E9018-B3
 LR AWS A5.5 E9018-B3
 DNV-GL -(H10)

Applications

- Low alloy steel (2.25%Cr-1%Mo)

Features

- Maximum service temperature at 600°C (1112°F)
- Good mechanical properties
- Good creep resistance
- Iron powder low hydrogen type electrode (high efficiency)

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Mo
0.08	0.64	0.83	0.020	0.011	2.11	1.0

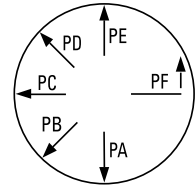
Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Heat Treatment
570 (82,800)	677 (98,300)	24.2	690°C(1274°F) X 1hr. S.R

Typical Welding Parameters / Amp.(A)

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

Welding Position



Current

AC, DC ±

Redrying Conditions

300~350°C (572~662°F) X
 0.5~1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard	
		packet 5kg(11lbs)	carton 20kg(44lbs)
2.6 (3/32)	350 (14)	✓	
3.2 (1/8)	350 (14)	✓	
4.0 (5/32)	400 (16)	✓	
5.0 (3/16)	400 (16)	✓	
6.0 (15/64)	450 (18)	✓	