

H ZULFI E 8018-B2

Brand Name & Classification

AWS/ASME SFA-5. 5: E 8018-B2
DIN 8575: E CrMo 1 B 20
EN 1599: E CrMo 1 B 42 H 10

Approvals Grade

Properties

Electrode for welding of creep resistant steels used in the construction of pressure vessels, boilers and piping subjected to operating temperatures up to +600° c. welds are of X-ray quality

Application

Creep resistant boiler and pipe steels e.g.
13 CrMo 44, 16 CrMo 44,
Cast steels GS-17Cr Mo 55, GS 22Cr Mo
54

Weld Metal Analysis Typical values

Carbon: 0.08

Silicon: 0.30

Manganese: 0.90

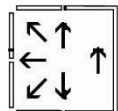
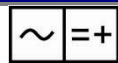
Molybdenum: 0.60

Chromium: 1.00

Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
>490 N/MM2	590 – 690 N/mm2	> 26 %	150 J at +20° c 60 J at -30° c

Welding Current & Positions



Current

Dia	Length	Amperes
2.6	350	70-100
3.2	400	90-140
4.0	400	140-190
5.0	400	190-250