

Brand Name & Classification

AWS/ASME SFA-5.5: E 9018-B3
DIN 8575: E CrMo 2 B 26
EN 1599: E CrMo 1 B 32 H10

Properties

Electrode for welding of creep resistant and high pressure hydrogen resistant steels used in the construction of pressure vessels, boilers and piping subject to operating temperatures up to +60⁰ c. Weld metal features high toughness properties and is largely insensitive to in service embrittlement .

Application

10Cr Mo 9 10, CM 10CD 9 10, 12CrMo 9 10, A387 Gr.22, Cl. 1 and A 182 Gr. F 22, A336 Gr. F 22 and F22a

**Weld Metal Analysis
Typical values**

Carbon: 0.06

Silicon: 0.50

Manganese: 1.10

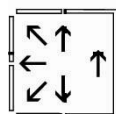
Nickel: 1.20

Molybdenum: 0.50

Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
Temp at 700 ⁰ c	Temp at 700 ⁰ c	Temp at 700 ⁰ c	Temp at 700 ⁰ c
Air Cool	Air Cool	Air Cool	Air Cool
>440 N/MM ²	>580 N/MM ²	>23	100J at +20 ⁰ c
Norm+Tem	Norm+Tem	%Norm+Te	Norm+Tem
15 Hrs at 920 ⁰ c	15 Hrs at 920 ⁰ c	m	15 Hrs at 920 ⁰ c
>350 N/MM ²	>550 N/MM ²	15 Hrs at 920 ⁰ c	150 J at +20 ⁰ c
		>24	

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