

**Brand Name & Classification**

AWS/ASME SFA-5.5: E 7018-A1  
DIN 8575: E Mo B 20  
EN 1599: E Mo B 42 H10

**Approvals Grade**

**Properties**

Electrode for welding of creep resistant steels used in the construction of pressure vessels, boilers and piping subject to operating temperatures up to +550<sup>o</sup> c . Welds are of X-ray quality. Preheating, interpass temperature and post weld heat treatment must be in accordance with the base metal to be welded.

**Application**

Creep resistant boiler and pipe steels, e.g. St 35.8, St 45.8, 17 Mn 4, 19 Mn 5, 15 Mo 3 16 Mo 5  
Fine grain structural steels StE and WStE 255 to 460  
Pipe steels StE 360.7 to StE 415.7 as well as corresponding TM grades  
Steels to API standards X 52 to X 60  
Cast steels GS-C 25, GS-22 Mo4

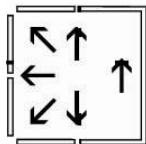
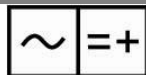
**Weld Metal Analysis  
Typical values**

Carbon: 0.06  
Silicon: 0.50  
Manganese: 0.80  
Molybdenum: 0.50

**Typical Mechanical properties**

Yield Strength	Tensile Strength	Elongation	Impact Strength
>470 N/MM2	520 – 650 N/mm2	> 22 %	160 J at +20 <sup>o</sup> c

**Welding Current & Positions**



**Current**

Dia	Length	Amperes
2.6	350	70-100
3.2	400/450	90-140
4.0	400/450	140-190
5.0	400/450	190-250