

CLASSIFICATIONS

**AWS A/SFA 5.5
IS 1395**

E 8018-B2
E 55 BB 226 Fe

EN 1599 E CrMo 1B42 H10
DIN 8575 E CrMo 1B 20+

COATING TYPE: Basic

DEPOSITION EFF., %: ~110

COATING FACTOR: Heavy

IDENTIFICATION: Brand Printed

CHARACTERISTICS

A low-hydrogen, iron-powder electrode for welding of 1.25% Cr-0.50% Mo creep resistant steels. Weld metal is creep and heat resistant upto 550°C. It gives excellent arc stability, arc smoothness and very easy slag removal. Weld metal is X-ray quality.

TYPICAL APPLICATIONS

Welding of 1.25%Cr-0.50% Mo and 1.0% Cr- 0.50% Mo steels used in Refineries, Power plants, Chemical plants, Pressure vessels, Boilers. Suitable for joining P4 materials e.g. F2, F11, F12 grades of SA-182/182M; T11 and T12 grades of SA-213/213M; P11, P12 grades of SA-335/335M; 2,11,12 grades of SA-387/387M etc.

APPROVALS

ABS E 8018-B2
IBR E 8018-B2
KRL E 8018-B2

NPCIL E 8018-B2
Toyo E 8018-B2

CURRENT CONDITIONS: AC (70V), DC (+)

5.0	4.0	3.2
190-	140-	100-
250	180	140

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS 300°C for 1 Hr

(Optionally also available in vacuum-packed condition, redrying not required in this packaging)

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	YS MPa	% Elong. (L=4xd)	CVN Impacts,J 27°C	Hardness, BHN
PWHT	560-680	470-600	22-28	50-100	225 max.

PWHT: Post weld heat treated at 690°C for 1 hr

WELD METAL CHEMISTRY, wt%

C - 0.05-0.09	S - 0.030 max.	Diffusible H ₂
Cr - 1.0-1.50	Mn - 0.50-0.90	Content ml/100gm
P - 0.030 max.	Si - 0.25-0.60	<5
Mo - 0.40-0.65		

PACKING DATA

Dia.,mm	6.3	4.0	3.0
Length,mm	450	450	450
Wt. per carton, kgs	5.0	5.0	5.0
Cartons/ box	4	4	4
Wt. per box, kgs	20	20	20

Related Products: Tigfil-80SG, Tigfil-15Cr, Cromoten Spl, Cromoten Ti, Cromoten PHT 5/12 Hrs Batch, Automig FC 8171-B2

