

# S-8018.B2

Type : Basic

## Conformances

AWS A5.5/ ASME SFA5.5 E8018-B2  
 JIS Z3223 E5518-1CM  
 EN 1599 - ECrMo1 B 3 2  
 ABS AWS A5.5 E8018-B2

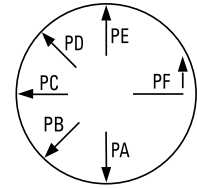
## Applications

- Low alloy steel (1.25%Cr-0.5%Mo)

## Features

- Iron powder and low hydrogen type electrode (high efficiency)
- Good mechanical properties
- Good creep resistance

## 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)		✓

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Mo
0.08	0.32	0.75	0.012	0.005	1.20	0.50

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Heat Treatment
563 (82,000)	641 (93,000)	27.6	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	-	-

SMW

SAW

GMW

GTAW

FCAW

Non-FERROUS

APPENDIX