

Covered Electrodes

K-8018B2

For heat-resisting steel (1.25%Cr-0.5%Mo)

Classifications

EN ISO 3580-A:2008	: E CrMo1 B 32 H10	KS D 7022	: DT2318
EN ISO 3580-B:2008	: E 55 18-1CM H10	JIS Z 3223	: DT2318
AWS A5.5-06	: E8018-B2		

Description

- Covering is low hydrogen, iron powder type for welding of 1.25%Cr-0.5%Mo steel used for steam pipes of boilers, oil refining industries, pressure vessels for high temperature service.
- Preheat at 150-300°C and postheat treat at 680-730°C
- High deposition rate in all positions.
- Redry the electrode at 300-400°C for 1~2 hours prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.06	0.61	0.70	0.014	0.011	0.02	1.32	0.55	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				20°C	0°C	
AWS A5.5	min. 460	min. 550	min. 19	≥ 47	65	PWHT
EN ISO 3580-A	min. 355	min. 510	min. 22			
Example	590	670	25	80		

* PWHT : 690°Cx1Hr

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amp.	F	65-95	90-130	130-190	190-250	250-300
(A)	V · OH	60-90	80-120	110-170	-	-

Approvals

ABS	DNV	LR
3YH10, E8018-B2	3YH10	3YmH15

* Others : CE