SM-8018-B2

SMAW ELECTRODE - LOW ALLOY, LOW HYDROGEN

CLASSIFICATIONS :

AWS A5.5	E8018-B2
ASME SFA A5.5	E8018-B2
JIS Z 3223	E5518-1CM
BS EN ISO 3580-A	E CrMo1 B 3 2

DESCRIPTION

SM-8018-B2 is an iron powder low hydrogen electrode designed for welding heat resistant boiler, plates and tubes. The electrode coated by iron powder marks characteristics of high working.

FEATURES

Smoother arc transfer, Easier slag removal, Less Spatter.
Excellent usability in all positions welding including vertical down.
Suitable for butt and fillet welding of thin plates/sheets.
Smooth and bright weld seams, Smoother with a finer ripple bead surface.
Stable arc on AC and DC.

APPLICATIONS

As its weld metal contains 1.25%Cr-0.5%Mo, SR-86B2 is suitably applied for ASTM A193 Gr. B7 ; A335 Gr. P11 a. P12 ; A217 Gr. WC6. ; A336 Gr. F12.

CHEMICAL COMPOSITION

	%C	%Mn	%Si	%P	%S
Requirements	0.05 - 0.12	0.9 max	0.8 max	0.030 max	0.030 max
Typical Results	0.06	0.43	0.2	0.01	0.01
	%Ni	**%Cr**	**%Mo**	**Additional Elements**	
Requirements	-	1.00 - 1.50	0.40 - 0.65	-	
Typical Results	0.02	1.01	0.52	-	

MECHANICAL PROPERTIES

	Tensile Strength, Mpa	Yield Strength, Mpa	Elongation, %
Requirements	550 min	460 min	17 min
Typical Results	670	590	26

OPERATING PROCEDURES

	Current (Amps)				
Polarity	Ø2.0 mm	Ø2.6 mm	Ø3.2 mm	Ø4.0 mm	Ø5.0 mm
AC	50 - 80	75 - 115	110 - 140	160 - 200	205 - 260
DC ±	45 - 75	70 - 105	100 - 135	145 - 180	185 - 235

WELDING POSITION

NOTE

1. Rebake the electrodes at 350 ~ 400°C for 60 minutes and keep at 100 ~ 150°C before use.
2. Proper preheat at 150 ~ 300°C and PWHT at 650 ~ 700°C.