CODIFICATION:
AWS : SFA 5.5 E8018-B2
IS : 1395 E 55BB2 26Fe

CHARACTERISTICS AND APPLICATIONS:
Weld metal having lesser impurities i.e. S, P, will improve the subzero impact property and retains its mechanical properties after prolonged heat treatments. Ideal for welding similar composition materials. The weld metal displays excellent tensile strength and creep resistance. Specially applicable wherever the impact property requirement at subzero temperatures up to minus 20°C.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:
Element : C  Mn  Si  Cr  Mo  S  P  Sn  As  Sb
Percent : 0.06  0.76  0.49  1.25  0.50  0.007  0.010  0.002  0.004  0.002

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:
(PWHT: 690°C FOR 1 HR)
UTS  (MPa)  YS  (MPa)  Elongation  (L = 4d)%  CVN Impact Strength  (at minus 20°C (Joules))  Creep Strength  (at 550°C)
620  530  22  80

DIFFUSIBLE HYDROGEN CONTENT:  5 ml/100 gms of weld metal (max.).
CURRENT AND PACKING DATA: DC(+)
Size (mm) : 6.3x450  5x450  4x350  3.15x350  2.5x350
Dia x Length
Current Range : 250-300  200-250  140-180  100-130  70-100
(Amps)
Qty.(Pcs./Carton) : 25  30  50  75  100

APPROVALS: BHEL

PRECAUTIONS:
1. Rebake the electrodes at 250-300°C as per our standard recommended practice.
2. Use short arc and stringer bead.

Note: Low carbon version Cromotherme 1L(MOD) conforming to AWS:E7018-B2L is also available.