CODIFICATION: AWS: SFA 5.5 E9018-B3
IS: 1395 E63 B B3 2 6 Fe

CHARACTERISTICS AND APPLICATIONS:
An iron powder, low hydrogen electrode producing a weld deposit containing 2.25Cr - 1Mo which is oxidation resistant up to 575°C. Suitable for welding 2.25Cr - 1Mo, Cr-Mo-V steels as well as cast steels of similar composition.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:
Element: C Mn Si Cr Mo S P
Percent: 0.06 0.80 0.44 2.40 1.10 0.025 0.025

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:
(PWHT: 690°C FOR 1 HR)
UTS (MPa) YS (MPa) Elongation (L = 4d)% Creep Strength (1% offset in 10,000 hrs)
644 554 22.0 at 550°C-12 kgf/mm² at 575°C-8.5 kgf/mm²

CURRENT AND PACKING DATA: DC(+)
Size (mm): 6.3x450 5x450 4x350 3.15x350 2.5x350
Dia x Length
Current Range: 260-320 180-240 140-180 100-130 70-100
(Amps)
Qty. (Pcs./Carton): 25 35 55 75 125

APPROVALS: Adani Infra, BHEL, CIB-MP, EIL, NTPC, PDIL, Reliance (SASAN Power)

PRECAUTIONS:
1. Redry the electrodes as per our standard recommended practice.
2. Use short arc during welding.