

SUNTHERM 8018 B8

High Tensile Creep Resistance Electrode



CLASSIFICATION

AWS/A 5.5 : E 8018 B8

CHARACTERISTICS

A basic coated low hydrogen iron powder electrode for welding of high strength creep resistant steels, ferritic, martensitic steels. Weld metal gives 9% Cr - 1% Mo and displays resistance to oxidizing atmosphere up to 700°C. Metal recovery is over 110%.

APPLICATIONS

Cr, Mo steels such as 9% Cr - 1% Mo steel plates, pipes & forging used in oil refineries, petro-chemical plants, power houses etc. Used for general corrosion & heat resistance application.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Sulphur	Phosphorus	Chromium	Molybdenum	Nickel
0.076	0.72	0.46	0.018	0.019	9.02	1.00	0.30

MECHANICAL PROPERTIES OF ALL WELD METAL % (TYPICAL):

Yield Strength	Ultimate Tensile Strength	Elongation (GL=4d)
504.0 N/mm ²	598.0 N/mm ²	23.40%

CURRENT CONDITION & PACKING DATA:

Size (mm)	Length (mm)	Current(Amp) AC 90 V or DC(+)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard box
2.50	350	70-100	5 Kg	20 Kg
3.15	450	100-130	5 Kg	20 Kg
4.00	450	140-180	5 Kg	20 Kg
5.00	450	180-240	5 Kg	20 Kg
6.30	450	240-300	5 Kg	20 Kg

RECOMMENDATIONS:

Redry the electrodes at 350°C for one hour or at 250°C for two hours. Keep the redried electrodes in a holding oven having 60°C-80°C temperature. Use short arc to the extent possible.