

## MIDALLOY CHROMAX E8018-B6 COATED ELECTRODE

### CLASSIFICATION

- AWS 5.5 Class E8018-B6 / ASME SFA 5.5 Class E8018-B6

### DESCRIPTION

- MIDALLOY CHROMAX E8018-B6 is an AC-DC (electrode positive), low alloy, coated electrode.

### APPLICATIONS

- For gas metal arc welding of chrome-moly steels of matching chemistry (5 Cr / 1/2 Mo).
- Used for elevated temperature service with corrosion resistance in superheated steam, hot hydrogen gas, and high sulphur crude oils.
- Typical applications include boiler superheaters, heat exchangers, piping and pressure vessels in oil refineries.

### TYPICAL CHEMISTRY

C	Mn	P	S	Si	Cr	Ni	Mo
0.07	0.42	0.020	0.01	0.14	5.38	0.10	.65

### TYPICAL MECHANICAL PROPERTIES

(Stress relieved 1 Hr. @ 1375°F)

TENSILE STRENGTH	101,000 PSI
YIELD STRENGTH	86,000 PSI
% ELONGATION IN 2"	23%
CHARPY V-NOTCH IMPACT @70° F	98
@21° C	133

### WELDING PARAMETERS

DIAMETER	3/32"	1/8"	5/32"	3/16"
AMPERAGE	70-100	90-160	130-200	200-300
VOLTAGE	21-33	21-33	21-24	22-25

### OTHER INFORMATION

- Preheat should be used on hardenable steels to prevent formation of a hard heat-affected zone.
- Preheat may also be required in welding heavy section.
- Opened containers should be stored at 225°F to 300°F. They can be reconditioned by baking for one hour at 700°F.

### STANDARD PACKAGING

- 3/32" 8 lb. can / 48 lb. box
- 1/8" 10 lb. can / 60 lb. box
- 3/16" 10 lb. can / 60 lb. box
- 5/32" 10 lb. can / 60 lb. box

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