

MIDALLOY CHROMAX E8018-B2 COATED ELECTRODE

CLASSIFICATION

- AWS 5.5 Class E8018-B2 / ASME SFA 5.5 Class E8018-B2

DESCRIPTION

- MIDALLOY E8018-B2 is an AC/DC (Electrode Positive) Low Alloy Coated Electrode.

APPLICATIONS

- For gas metal arc welding of various Cr/Mo steels, primarily 1¼ Cr and ½ Mo principally used in power piping and boiler work for the fabrication of plates, pipes, tubes, castings and forgings.

TYPICAL CHEMISTRY

| C | Mn | Si | P | S | Cr | Mo |
|-------|------|------|-------|-------|------|------|
| 0.067 | 0.64 | 0.45 | 0.016 | 0.014 | 1.23 | 0.55 |

TYPICAL MECHANICAL PROPERTIES

| | STRESS RELIEVED 1 HOUR @ 1275°F | STRESS RELIEVED 8 HOURS @ 1275°F |
|--------------------|------------------------------------|-------------------------------------|
| TENSILE STRENGTH | 89,700 PSI | 85,800 PSI |
| YIELD STRENGTH | 77,400 PSI | 71,800 PSI |
| % ELONGATION IN 2" | 26% | 27% |

WELDING PARAMETERS

| DIAMETER | 3/32" | 1/8" | 5/32" | 3/16" |
|----------|----------|--------|---------|---------|
| AMPERAGE | 70 – 100 | 90-160 | 130-220 | 200-300 |
| VOLTAGE | 21-23 | 21-23 | 21-24 | 22-25 |

OTHER INFORMATION

- Preheat should be used on hardenable steels to prevent the formation of a hard heat-affected zone.
- Preheat may also be required in welding heavy sections.
- 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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