

MIDALLOY E8018-B8 H4R Electrodes
(Formerly MIDALLOY E505-16 AWS 5.4)

CLASSIFICATION

- Meets AWS 5.5 Class E8018-B8 H4R / ASME SFA 5.5 Class E8018-B8 H4R.
- Prior classified was AWS/SFA 5.4 E505-16.
- ASME F-4, A-5

DESCRIPTION

- MIDALLOY MASTERCOR E8018-B8 H4R is low Hydrogen, “All-Position” shielded metallic arc electrode particularly suited for pipe welding.

APPLICATIONS

- For joining applications on higher Chromium 9Cr steel (UNS S50500), ASTM A387 Grade 9.
- These types of steels are used in piping systems for elevated temperatures and pressures.
- This alloy offers improved toughness and better creep properties, which allow for higher steam temperatures.
- Excellent recovery of elements over a variety of parameters and positions.

TYPICAL CHEMISTRY

C	Mn	P	S	Cr	Mo	Ni	Si	Cu
0.06	0.80	0.009	0.010	8.43	0.85	0.038	0.75	0.11

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	101 KSI
YIELD STRENGTH	89 KSI
ELONGATION	22%
ENERGY ABSORPTION FT. LBS. (CHARPY’S)	Not Required

- Mechanical Properties after PWHT at 1375°F for 1 hour

WELDING PARAMETERS

DIAMETER	Amperage
3/32”	70-110
1/8”	90-160
5/32”	130-210

- DC Reversed Polarity

STANDARD PACKAGING

- 10 Lb. or 50 Lb Cans

11/16/10

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