

MIDALLOY CHROMAX E8018-B6 H4R COATED ELECTRODE

CLASSIFICATION

- AWS 5.5 Class E8018-B6 H4R / ASME SFA 5.5 Class E8018-B6 H4R
- Prior classification was AWS/SFA 5.4 E502-16
- ASME F-4, A-5

DESCRIPTION

- MIDALLOY CHROMAX E8018-B6 H4R is a low hydrogen, low alloy, "all position" shielded metal arc electrode Particularly suited for pipe welding.

APPLICATIONS

- For joining applications 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

TENSILE STRENGTH	87,000 PSI
YIELD STRENGTH	72,000 PSI
% ELONGATION IN 2"	24%

- Mechanical Properties after PWHT at 1375° for 1 hour

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" 10 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

12/2/15

The contents of this publication are presented for informational purposes only, and while every effort has been made to ensure their accuracy, they are not to be construed as warranties or guarantees, express or implied, regarding the products or services described herein or their use or applicability. We reserve the right to modify or improve the designs or specifications of such products at any time without notice.