

MIDALLOY CHROMAX E9018-B3 COATED ELECTRODE

CLASSIFICATION

- AWS 5.5 Class E9018-B3/ASME SFA 5.5 Class E9018-B3

DESCRIPTION

- MIDALLOY E9018-B3 is an AC/DC (Electrode Positive) Low Alloy Coated Electrode.

APPLICATIONS

- For gas metal arc welding of Cr/Moly steels of matching chemistry, primarily 2-1/4 Cr and 1 Mo, principally used on pressure vessels, heat exchangers, and other related components.

TYPICAL CHEMICAL COMPOSITION

C	Mn	Si	P	S	Cr	Mo
0.07	0.66	0.48	0.019	0.014	2.25	1.05

TYPICAL MECHANICAL PROPERTIES

	STRESS RELIEVED 1 HOUR @ 1275°F	STRESS RELIEVED 8 HOURS @ 1275°F
TENSILE STRENGTH	99,500 PSI	94,200 PSI
YIELD STRENGTH	83,300 PSI	78,600 PSI
% ELONGATION IN 2"	23%	23%

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

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