

SUNTHERM 8018 B2

Low Hydrogen Electrode



CLASSIFICATION

AWS/A 5.5 : E 8018 B2

IS 1395-82 : E55B-B2 26Fe

CHARACTERISTICS

An outstanding hydrogen controlled iron powder type electrode used for higher tensile strength steels with tensile more than 550N/mm². The weld metal displays excellent strength and creep resistance at elevated temperature up to 550°C. Metal recovery is above 110%.

APPLICATIONS

Hardenable low alloy steels, Equipment subjected to high stress and dynamic loading, Pressure vessel, Heavy and rigid structure, Thick plates of Carbon steel.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Sulphur	Phosphorus	Chromium	Molybdenum
0.072	0.70	0.48	0.019	0.017	1.18	0.43

MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL) (AS PER IS 814-04)

Yield Strength	Ultimate Tensile Strength	Elongation (GL=4d)	Reduction in Area	CVN Impact Values at minus 30°C
504.0 N/mm ²	598.0 N/mm ²	23.40%	68%	54 Joules avg

CURRENT CONDITION & PACKING DATA:

Size (mm)	Length (mm)	Current(Amp) AC 70 V or DC(+)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard box
2.50	350	70-100	5 Kg	20 Kg
3.15	450	100-130	5 Kg	20 Kg
4.00	450	140-180	5 Kg	20 Kg
5.00	450	180-240	5 Kg	20 Kg
6.30	450	240-300	5 Kg	20 Kg

RECOMMENDATIONS:

Re-dry the electrodes at 350°C for one hour or at 250°C for two hours. Keep the re-dried electrodes in a holding oven having 60°C-80°C temperature. Use short arc to the extent possible.