

SUNTHERM 8018 B6

Low Alloy Creep Resistance Electrode



CLASSIFICATION

AWS/A 5.5 : E 8018 B6

IS 1395-82 : E41B-B6 26Fe

CHARACTERISTICS

A medium heavy coated iron powder, hydrogen controlled electrode producing a weld deposit containing 5 Cr-0.5 Mo. The weld metal has excellent creep resistance at elevated temperatures up to 650°C. Welds are of radiographic quality and metal recovery is over 110%.

APPLICATIONS

Welding of creep resistance steel plates, forging pipes containing 4-6 Cr and 0.5 Mo. Employed in oil refineries, power houses, petrochemical plants, fertilizer plants etc.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Sulphur	Phosphorus	Chromium	Molybdenum	Nickel	Copper
0.076	0.78	0.50	0.018	0.019	5.18	0.49	0.28	0.20

MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL)

Yield Strength	Ultimate Tensile Strength	Elongation (GL=4d)	CVN Impact Values at minus 30°C
484.0 N/mm ²	598.0 N/mm ²	22.40%	104 Joules avg

CURRENT CONDITION & PACKING DATA:

Size (mm)	Length (mm)	Current(Amp) AC 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 60-80°C temperature. Use short arc to the extent possible.