

SUNTHERM 9018 B3

Low Hydrogen Electrode



CLASSIFICATION

AWS/A 5.5 : E 9018 B3

IS 1395-82 : E63B-B3 26Fe

CHARACTERISTICS

Hydrogen controlled iron powder type electrode yielding a deposit of 2.25% Cr & 1.0% Mo. Due to resistance to moisture re-absorption hydrogen cracking & starting porosities are avoided. The welds are of radiographic quality. Excellent strength & creep resistance of elevated temp. up to 550°C.

APPLICATIONS

Welding of 2.25% Cr-1% Mo, Creep resistant steels, Cr-Mo and Cr-Mo-V steels, Steam boiler, Steam and Super heart piping, Power plants and chemical plants, Oil refineries.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Sulphur	Phosphorus	Chromium	Molybdenum
0.075	0.70	0.42	0.019	0.017	2.3	1.0

MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL)

Yield Strength	Ultimate Tensile Strength	Elongation (GL=4d)	Reduction in Area
508.0 N/mm ²	660.0 N/mm ²	21.80%	62%

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. Use short arc to the extent possible.