Inweld 8018-B2

AWS A5.5 E8018-B2

Chemical Composition of Inweld 8018-B2

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
Balance	0.05-0.12	1.00-1.50	---	0.40-0.65	0.90	0.80	0.03	0.03	---	---

Single values are maximum unless otherwise specified.

Description and Applications

Low Alloy, Low Hydrogen, Iron Powder electrode for welding 1-1/4 Cr - 1/2 Mo steels subjected to high pressure and temperatures. X-Ray quality weld deposits meet or exceed AWS/ASTM Charpy Impact requirements. Smooth arc, low spatter, fine bead appearance with exceptional mechanical properties. Common applications include steam pipes of boilers for power plants, equipment used in the oil refinery industry, synthetic chemical plants and ships. (ASTM A355 P2, P11, P12, A119-T11, A301-B, A217-WC6, A182-F11)

Typical Weld Metal Properties

	AWS Spec
Tensile Strength:	80,000 psi
Yield Strength:	60,000 psi
Elongation:	20%

Recommended Parameters

SMAW (DCEP – Electrode+)

Wire Diameter	Voltage	Amperage
3/32”		60-110
1/8”		85-160
5/32”		110-210