Inweld 9018-B3

AWS A5.5 E9018-B3

Chemical Composition of Inweld 9018-B3

C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu	Fe
0.05-0.12	2.00-2.50	---	0.90-1.20	0.90	0.80	0.03	0.03	---	---	Balance

Single values are maximum unless otherwise specified.

Description and Applications

These low-hydrogen electrodes produce weld metal that contains between 1/2% and 9% chromium and between 1/2% and 1% molybdenum. They are designed to produce weld metal for high-temperature service and for matching the properties of the typical base metals.

This electrode produces a weld metal with about 0.08% carbon that can improve ductility and lower hardness, but this also reduces the high-temperature strength and creep resistance of the weld metal.

Since all Cr-Mo electrodes produce weld metal which will harden in still air, both preheat and post-weld heat treatment are required for most applications.

Procedure

Typical Weld Metal Properties

	AWS Spec (ksi)
Tensile Strength:	90,000
Yield Strength:	77,000
Elongation:	17%

Recommended Parameters

SMAW - AC or DCEP

Wire Diameter	Voltage	Amperage
3/32		70-100
1/8		115-165
5/32		150-220