Inweld 9018-B9

AWS A5.5 E9018-B9

Chemical Composition of Inweld 9018-B9

C	Cr	Ni	Mo	Mn	Si	P	S	V	Cu	Al	Nb (Cb)	N
0.08-0.13	1.25	1.0	0.85-1.20	1.25	0.30	0.01	0.01	0.15-0.30	0.25	0.04	0.02-0.10	0.02-0.07

Single values are maximum unless otherwise specified.

Description and Applications

This low-hydrogen electrode modified with niobium (columbium) and vanadium designed to provide improved creep strength, toughness, fatigue life, and oxidation and corrosion resistance at elevated temperatures. Due to the higher elevated temperature properties of this alloy, components that are fabricated from stainless and ferritic steels may be fabricated from a single alloy, eliminating problems associated with dissimilar welds.

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