Covered Electrodes

K-8018B2

For heat-resisting steel (1.25%Cr-0.5%Mo)

KISWEL

Classifications

EN ISO 3580-A:2006	: E CrMo1 B 32 H10
EN ISO 3580-B:2006	: E 55 18-1CM H10
AWS A5.5-06	: E8018-B2
KS D 7022	: DT2318
JIS Z 3223	: DT2318

Approvals

ABS	: 3YH10, E8018-B2
DNV	: 2YH15
LR	: 2YmH15
Other	: CE

Description

- Covering is low hydrogen, iron powder type for welding of 1.25%Cr-0.5%Mo steel used for steam pipes of boilers, oil refining industries pressure vessels for high temperature service
- Preheat at 150 - 300 °C and post heat treat at 680 - 730 °C
- High deposition rate in all positions
- Redry the electrode at 300 – 400 °C for 1 – 2 hours prior to use

Welding positions

Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.06	0.61	0.70	0.014	0.011	0.2	1.32	0.55	0.01

Typical mechanical properties of all-weld metal

	Yield Strength	Tensile Strength	Elongation	Impact Value (J)		Remarks
	(MPa)	(MPa)	(%)	20 °C	0 °C	
AWS A5.5	Min. 460	Min. 550	Min. 19			
EN ISO 3580-A	Min. 355	Min. 510	Min. 22	≥ 47		
Example	590	670	25	80	65	PWHT

*PWHT: 690 °C x 1Hr

Sizes available and recommended currents (AC or DC +)

Diameter	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amperage	F	65-95	90-130	130-190	190-250	250-300
	V . OH	60-90	80-120	110-170	-	-