8018-B2 FOR (C.A.C.C.) ARC

SPECIAL WELDING ROD WITH LOW HYDROGEN CONTENT AND POWDER IRON COVERING. ITS FILLER METAL HAS HIGH MECHANICAL RESISTANCE AND IT IS A LOW CHROMIUM-MOLYBDENUM ALLOY.

CLASSIFICATION A.W.S: E8018B2

IDENTIFICATION: GREY COATING

APPLICATIONS: It is recommended for construction and maintenance work with low alloy steel used in preheating units, oil refinery high temperature pipes (cracking tubes), heat exchangers, boilers, etc. where working temperatures reach up to 550°C. 8018B2 welding rods are recommended for the following kinds of steel (ASTM specifications):

A 155 - 74 Gr. CM75 A 217 - 65 Gr. WC4
A 155 - 74 Gr. ½,1,1,1/4, Cr. A 234 - 65 Gr. WP
182-74 Gr. F2,F11, F12 and L10 A 336 - 70ª Gr
A 199 - 64 Gr. T11 A 356 - 74 Gr. 5
A 200 - 72 Gr. T11 A 369 - 64 Gr. A 213 - 74 b Gr. 72, T11 , T12 , T17
A 350 - 74 Gr. LF3 A 389 - 74 Gr. C23

CHARACTERISTICS AND PROCEDURE: This welding rod can be used in all positions. The resulting weld seams are flat, smooth, without cavities or splatter. Clean the joint area to remove dirt, scales, grease and rust. Keep the arc short with the welding rod slightly tilted in the direction of the weld. Swinging while welding should not exceed the core diameter by 3. When using DC, connect the electrode holder to the positive pole (reverse polarity). Remove the slag between one pass and the next. Precaution: Electrodes with low hydrogen content coverings are hygroscopic (they tend to absorb and retain water from the surrounding air) so they have to be kept in a dry, hot place.

TENSILE RESISTANCE:	6,600 KG./CM2 (94,000 PSI)
ELASTIC LIMIT:	5,694 KG./CM2 (81,000 PSI)
ELONGATION IN 5 cm:	25%
CHARPY V:	N/A
BRINELL HARDNESS:	190 BHN
POSITIONS:	ALL
CURRENT:	AC or DC REVERSE POLARITY

FILLER METAL CHEMICAL ANALYSIS %					SIZES	AMPERAGE
C	**Mn**	**Si**	**Cr**	**Mo**		
0.08	0.90	0.60	1.0-1.5	0.4-0.65	4.0 mm - 5/32"	140-180
					5.0 mm - 3/16"	200-250