

## 9018-B3 FOR (C.A.C.CASDASD.) ARC

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

CLASSIFICATION A.W.S: E 9018-B3

IDENTIFICATION: GREY COATING

**APPLICATIONS:** It is recommended to weld equipment and devices in which the working temperatures reach up to 625°C as boilers, transformers, converters, oil refinery high temperature pipes (cracking tubes), heat exchangers, etc.

E-9018B3 electrodes are recommended for the following kinds of steel ( ASTM specifications):

A 199 - 64 Gr. T3 and T4 oooooooooooooooooooooo A 356 - 65 Gr. 4,8 and 10

A 200 - 64 Gr. T22. oooooooooooooooooooooooooooooA 234 - 65 Gr. WP

A 213- 64 Gr T22. oooooooooooooooooooooooooooooA 369 - 65<sup>a</sup> Gr FP21

A 217 -65Gr.WC9 oooooooooooooooooooooooooooooA 356 - 74 Gr. 5

A 335 - Gr. P22 and P21 A 369 - 65 Gr. oooooooooooooA 336 - Gr. F22 A 542-C1 1/2

A 389 - 63

A 199 - 64 Gr. T3 and T4 oooooooooooooooooooooooooooooA356 - 65 Gr. 4.8 Y 10

**CHARACTERISTICS AND PROCEDURE:** This electrode filler metal has a very nice appearance and the resulting weld seams are flat, smooth, without cavities or splatter. The slag can be easily removed. It can be used in all positions. Clean the joint area to remove dirt, scales, grease and rust. Keep the arc short with the electrode slightly tilted in the same direction as the weld. Swinging while welding should not triple the core diameter. 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 a low hydrogen content covering are hygroscopic (they tend to absorb and retain water from the surrounding air) so they should be kept in a dry, hot place.

<b>TENSILE RESISTANCE:</b>	7,170 KG./CM2 ( 102,000 PSI )
<b>ELASTIC LIMIT:</b>	6,186 KG./CM2 ( 88,000 PSI )
<b>ELONGATION IN 5 cm:</b>	25%
<b>CHARPY V:</b>	N/A
<b>CURRENT:</b>	AC or DC REVERSE POLARITY

FILLER METAL CHEMICAL ANALYSIS %					SIZES	AMPERAGE
C	Mn	Si	Cr	Mo	3.25 mm - 1/8"	100-130
0.07	0.75	0.60	2.20	1.05	4.0 mm - 5/32"	140-180
					5.0 mm - 3/16"	200-250