

Applications

S-8018.B2 can be used for welding of 1.25%Cr-0.5%Mo heat resistant steel used for steam pipes of boilers for electric power plant and marine use, equipment for oil refining industries and high temperature synthetic chemical industries. Most commonly used in steam power plants, central power stations and ships, chemical plants and refineries.

Characteristics on Usage

S-8018.B2 is an iron powder low hydrogen type electrode. Its coating contains much iron powder, which increasing working efficiency. Owing to this high working efficiency, it is mostly suitable for welding thick steam pipes and repair welding of cast steel.

Notes on Usage

- ① Preheat at 150~300°C(302~572°F) and postheat at 670~730°C(1238~1346°F).
- ② Dry the electrodes at 350~400°C(662~752°F) for 60 minutes before use.
- ③ Keep the arc as short as possible.

Welding Position



1G (PA) 2F (PB) 3G (PF) 4G (PE)

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Mo
0.08	0.32	0.75	0.012	0.005	1.20	0.50

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Heat Treatment
563 (82,000)	641 (93,000)	27.6	690°C(1274°F) × 1hr. S.R

Approval

ABS

I Packing

Packet 5 kg (11 lbs)
Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm(in)	350 (14)	350 (14)	400 (16)	400 (16)	450 (18)
F	55~90	90~130	130~190	190~240	240~300
V-up, OH	50~80	80~120	120~170	-	-