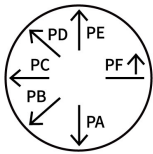


S-9018.B3

Classification

- AWS** A5.5/ASME SFA-5.5 E9018-B3
- JIS** Z 3223 E6218-2C1M
- EN** ISO 3580-A E CrMo2 B 3 2

Welding Positions



Features

- Maximum service temperature at 600°C (1112°F)
- Good mechanical properties
- Good creep resistance
- Iron powder low hydrogen type electrode (high efficiency)

Polarity

AC, DC ±

Application Areas

- Low alloy steel (2.25% Cr-1% Mo)
- Pressure vessels
- Power plants

Redrying Conditions

300~350°C (572~662°F) X 0.5~1hr

Approvals

ABS	DNV	KR	LR
✓	✓	✓	✓

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S	Cr	Mo
0.08	0.21	0.58	0.015	0.011	2.13	1.10

Typical Mechanical Properties of All-Weld Metal

PWHT	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)
690°C*1hr	564(82)	674(98)	24

SMAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.6 (3/32)	350 (14)	50~90	50~80	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
3.2 (1/8)	350 (14)	90~130	80~120	
4.0 (5/32)	400 (16)	130~190	120~170	
5.0 (3/16)	400 (16)	190~250	-	
6.0 (15/64)	450 (18)	250~300	-	

SWAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux