

CEWELD E 8018-B2

TYPE Basic stick electrode for welding similar Cr-Mo alloyed steels. (Type 1Cr-0,5Mo ; E8018-B2)

APPLICATIONS CEWELD® E 8018-B2 is a basic stick electrode for welding joints made of similar Cr-Mo alloyed steels.
It is used for welding in: Steam plant construction, plant and tank construction, waste plant construction, boiler plant construction, pipe production, heat exchanger production, etc.

PROPERTIES The basic coating of CEWELD® E 8018-B2 guarantees a low content of diffusible hydrogen in the weld metal (HD < 5 ml/100 g) and an output of 120 %.
It is suitable for welding medium alloyed steels and shows resistance at high temperatures up to 550 °C in the long-term range

CLASSIFICATION

AWS	A 5.5: E 8018-B2
EN ISO	3580-A: E CrMo1 B 42 H5
F-nr	4
FM	3

SUITABLE FOR **Typ 1Cr0,5Mo, ISO 15608: ~5,1**
1.7205, 1.7218, 1.7225, 1.7228, 1.7254, 1.7258, 1.7262, 1.7335, 1.7337, 1.7350, 1.7354, 1.7357, 1.7728
13CrMoV42, 13CrMo4-4, 13CrMo4-5, 15CrMo3, 15CrMo5, 13CrMoV42, 15Cr3, 16MnCr5, 20MnCr5, 15CrMo5, 24CrMo5, 25CrMo4, GS-22CrMo5, GS-22CrMo54, GS 17CrMo5-5, 16CrMoV4, 42CrMo4, 42CrMo4V, 41CrMo4V,
ASTM A 182 Gr. F11 / F12; A 193 Gr. B7; A 213 Gr. T12; A 217 Gr. WC6; A 234 Gr. WP11; A335 Gr. P11, P12; A 336 Gr. F11, F12; A 426 Gr. CP12 ; A 199; A200; A 387 Gr A11 / 12

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

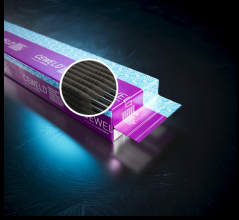
C	Si	Mn	P	S	Cr	Mo
0.09	0.5	0.8	0.025	0.02	1.2	0.5

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT	-20°C	
690°C±15°C 1h	520	610	23	120	60	HRc

REDRYING 400°C / 1 hr

GAS ACC. EN ISO 14175



CEWELD E 8018-B2

E 8018-B2 2,5 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720682050859

E 8018-B2 3,2 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720682050866

E 8018-B2 4,0 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,4	8720682050873