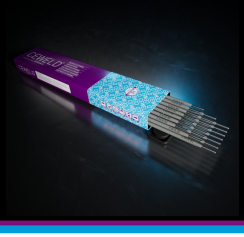


CEWELD E 8018-B2

certilas® THE FILLER METAL SPECIALIST

TYPE	Cr and Mo-alloyed basic low hydrogen coated electrode
ANWENDUNGEN	Steam plants, vessel, waste plants, cementation steels, boiler works, tubes, heat exchangers
EIGENSCHAFTEN	Basic electrode for welding of steam production plants, steam pipes and similar joints made of Cr-Mo alloyed steel. The weld metal is resistant to working temperatures up to 550°C. as for similarly alloyed steels, quenched and tempered for cementation and nitrating. Hydrogen content: HD < 5 ml/100 g weld metal

KLASSIFIKATION

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

GEEIGNET FÜR

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
1.7205, 1.7218, 1.7225, 1.7228, 1.7254, 1.7262, 1.7335, 1.7337, 1.7350, 1.7354, 1.7357,
ASTM: A182 grades F11/F12, A199/A20 grade T11, A193 Grade B7, A217 grades WC6/WC11, A335 Grade P11, A335 Grade P12, A387 grades 11/12

ZULASSUNGEN

CE

SCHWEISSPOSITIONEN

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Mo
0.1	0.5	0.8	0.025	0.02	1.1	0.5

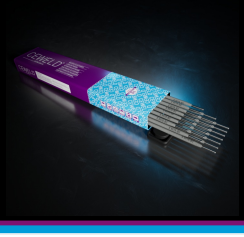
MECHANISCHE GÜTEWERTE

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	490	610	23	90	HRc

RÜCKTROCKNUNG

400°C / 1 hr

GAS ACC. EN ISO 14175



CEWELD E 8018-B2

E 8018-B2 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	2,4	8720663401243

E 8018-B2 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663401267

E 8018-B2 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663401281