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# Product: SPARK – E 8018-B2

**Classification:** AWS/ASME SFA-5.5 E 8018-B2

EN ISO 3580-A E CrMo1 B 42 H5

**Application/Properties:** Electrode for welding creep resistant steels of similar composition. Weld metal is of high purity and low hydrogen content. Creep resistant < 5700 c Welds are of X Ray quality.

**Suitable for:**

13 CrMo4-5, 13 CrMoSi5-5, G17CrMo5-5

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| **Sizes and Currents**  **AC or DC+** | Diameter | Length | Current (A) |
| 2.6mm  3.2mm  4.0mm  5.0mm | 350mm  450mm  450mm  450mm | 70 – 100  90 – 140  140 – 190  190 - 250 |

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| --- | --- | --- | --- | --- | --- | --- | --- |
| **Weld metal analysis:** | C | Si | Mn | Cr | Mo | P | S |
| 0.06 | 0.30 | 0.75 | 1.20 | 0.55 | 0.011 | 0.011 |

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|  | **6900 c/2h** | **9200 c/0.5h** |
| **Mechanical properties**  **of all weld metal:** | Yield Strength | > 490 N/mm2 | > 300 N/mm2 |
| Tensile Strength | 560 - 690 N/mm2 | 450 - 550 N/mm2 |
| Elongation L.=5D. | > 23% | > 26% |
| Impact Strength | >120 J at +200C  >80 J at -300C | >130 J at +200C  >80 J at –300C |

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| **Packaging:** | 2.6mm | 8x2.5kg.packet/carton |
| 3.2 mm | 4x5.0 kg. packet/carton |
| 4.0 mm | 4x5.0 kg. packet/carton |
| 5.0 mm | 4x5.0 kg. packet/carton |
|  | 1 MT/pallet |