

## Covered Electrodes

# K-9018B3

For heat-resisting steel (2.25%Cr-1%Mo)

### Classifications

EN ISO 3580-A:2008	: E CrMo2 B 32 H10	KS D 7022	: DT2418
EN ISO 3580-B:2008	: E 62 18-2C1M H10	JIS Z 3223	: DT2418
AWS A5.5-06	: E9018-B3		

### Description

- Covering is low hydrogen, iron powder type for all positions welding of 2.25%Cr-1%Mo steel used for steam pipe of boilers, oil refining industries, pressure vessels for high temperature service.
- Preheat at 150~300°C and postheat treat at 680~730°C
- High deposition rate in all positions.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

### Welding positions



### Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.08	0.50	0.77	0.018	0.011	0.03	2.25	1.02	0.01

### Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				20°C	0°C	
AWS A5.5	min. 530	min. 620	min. 17			
EN ISO 3580-A	min. 400	min. 500	min. 18	≥ 47		
Example	680	750	21	50	35	PWHT

\* PWHT : 690°Cx1Hr

### Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	350	350	400	400
Amp. (A)	F V · OH	60~100 60~90	90~130 80~120	140~190 110~170	190~250 -

### Approvals

CE