

# K-8018B2

AWS E8018-B2  
JIS DT2318  
KS DT2318

FOR HEAT-  
RESISTING STEEL

## Typical applications

Welding of 1.25%Cr-0.5%Mo steel used for steam pipes of boilers, oil refining industries, castings and pressure vessels for high temperature service, high temperature synthetic chemical industries.

## Coating

Low hydrogen, iron powder type.

## Characteristics on Usage

- ① Owing to the high working efficiency, it is the most suitable for welding thick steam pipes and repairing cast steels.
- ② Preheat at 150~300°C and postheat treat at 670~730°C
- ③ Redry the electrode at 300~350°C for 60 minutes prior to use.

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

C	Si	Mn	Cr	Mo
0.06	0.61	0.70	1.32	0.55

## Typical mechanical properties of all-weld-metal

Temp.	Y · P N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	EI (%)	PWHT
R.T	590 {60}	670 {68}	25	690°C × 1hr. S-R
450°C	470 {48}	550 {56}	17	

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

Dia.	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amp.	F	65~95	90~130	130~190	190~250	250~300
	V&OH	60~90	80~120	110~170	-	-

## Welding positions



Approved by

ABS, DNV, LR