

FOR HEAT-
RESISTING STEEL

AWS E9018-B3
JIS DT2418
KS DT2418

K-9018B3

Typical applications

Welding of 2.25%Cr-1%Mo steel used for main steam pipes of boilers for electric power plant and marine use, equipments for oil refining industries and high temperature synthetic 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 main pipes and repairing cast steel.
- ② Preheat at 200~350°C and postheat treat at 680~730°C.
- ③ Redry the electrodes at 300~350°C for 60 minutes prior to use.

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

C	Si	Mn	Cr	Mo
0.08	0.50	0.77	2.25	1.02

Typical mechanical properties of all-weld-metal

Temp.	Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	EI (%)	PWHT
R.T	680 {69}	750 {77}	21	690°C × 1hr. S · R
450°C	500 {51}	550 {56}	9	

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.	F	60~100	90~130	140~190	190~250
	V&OH	60~90	80~120	110~170	—

Welding positions



Approved by