RASI ELECTRODES LIMITED

AN ISO 9001 : 2008 CERTIFIED COMPANY

MADE IN INDIA

RASI E 9018-B3

premium

BASIC COATED LOW HYDROGEN ELECTRODEs

TECHNICAL SPECIFICATION SHEET

CHARACTERISTICS

RASI E 9018 - B3 is a medium heavy coated, hydrogen controlled Iron powder type all position electrode with a deposition efficiency of approximately 105% the weld metal is having 2.25% Cr, 1% Mo. Welds are radiographically sound, Creep resistance upto 600°C.

APPLICATIONS

Suitable for welding of similar Cr-Mo steels such as German 10Cr Mo9 and 10Cr Si Mo V7. Low alloy steel boilers and piping operating at Service temperature upto 6000C. In oil refinery thermal and chemical plant, repair of high tensile steel castings.

CLASSIFICATIONS

IS : 1395 E-63B326 Fe
AWS / SFA 5.5E 9018-B3

CHEMICAL COMPOSITION OF ALL WELD METAL

Carbon - 0.12%
Manganese - 0.90%
Phosphorus - 0.03%
Mo - 1.2%
Silicon - 0.80%
Sulfur - 0.03%
Cr - 2.5%

Note: Single Values shown above are maximum

MECHANICAL PROPERTIES OF ALL WELD METAL

Tensile Strength (N/mm²) - 620 MIN.
Yeild Strength (N/mm²) - 530 MIN.
Elongation % - 17 - 25%.
CVN Impact at 0°C - 40 J MIN.

WELDING CURRENT : DC± / AC 50 V

Ø 2.50 mm - 60 - 100 Amps
Ø 3.15 mm - 100 - 140 Amps
Ø 4.00 mm - 140 - 190 Amps
Ø 5.00 mm - 190 - 240 Amps.
Ø 6.30 mm - 240 - 300 Amps.

***FOR APRROVALS AND CERTIFICATIONS KINDLY CONTACT :- info@rasielectrodes.com**

storage - Store in warm and dry place. If damped re dry at 300°C for 1 hour.

*All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

www.rasielectrodes.com

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