

LOW HYDROGEN & LOW ALLOY

## RASI E 8018-B6

5Cr - ½ MOLY STEEL

### CLASSIFICATIONS :

SFA 5.5 AWS E 8018-B6  
IS : 1395 E 55B-B1-26Fe

### CHARACTERISTICS :

**RASI E 8018 B6** is a low Hydrogen and Low Alloy basic coated all position except vertical down welding electrode and it gives the weld metal of 6% Cr. The electrodes produce weld metal which will harden in still air. The welds are Radio graphically sound.

### APPLICATIONS :

The electrodes are well suited for welding of pressure vessels, piping, valves and tanks used for oil refineries and chemical plants etc.

### CHEMICAL COMPOSITION OF ALL WELD METAL

ELEMENTS	C	Mn	Si	Ni	Cr	Mo	S	P
PERCENTAGE	0.1	1.0	0.90	0.4	4-6	0.46-0.60	0.03	0.03

### MECHANICAL PROPERTIES OF ALL WELD METAL PWHT

UTS (N/mm <sup>2</sup> )	YS N/mm <sup>2</sup>	Elongation % L = 4D
550 Min	480Min	19 Min

### WELDING CURRENT & PACKING DATA : AC70V/DC(+)

#### ELECTRODE SIZE, CURRENT RANGE & PACKING

Dia (mm)	2.5 x 350	3.15 x 450	4.0 x 450	5.0 x 450
Current (A)	60-90	100-130	140-180	180-250
Pieces/Pkt/Kg	184/4 Kg	93/4 Kg	60/4 Kg	40/4 Kg
Pkts/Box	4/16 Kg	5/20 Kg	5/20 Kg	5/20 Kg

### STORAGE

Re-dry the Electrode at 300°C for 1 Hr, use short arc during welding store the electrode in dry conditions.