DURAMAX®
Inspiring the future generations of welders

PRODUCT DATA SHEET

DM8018-B2 Premium Electrode

Classification: **E8018-B2**

AWS A 5.5 / ASME SFA 5.5

DuraMax DM8018-B2 is a HYDROGEN CONTROLLED IRON POWDER ELECTRODE FOR WELDING CREEP-RESISTANT 1Cr-0.5Mo STEELS.

Characteristics

A medium heavy coated, hydrogen controlled, iron powder type, all position radiographic quality electrode to weld 1.25% Cr - 0.50% Mo steel, having increased working efficiency. Electrode has properties of creep resistance up to 550°C.

Typical Applications on Usage

1) Suitable to weld creep resistant steels like Cr-Mo pipelines and plates used in oil refineries.
2) Power plants, steam boilers.
3) Equipment subject at high temperatures in synthetic chemical units.
4) Repairs of cast steel components.
5) Parts of automobiles / earth-moving machineries.

RE-DRY CONDITIONS: Re-Dry the electrode at 250°C for 1 hour before use.

All Weld Chemical Composition (%)

C	Mn	Si	Cr	Mo	S	P
0.05 - 0.12	0.90 max	0.60 max	1.00 - 1.50	0.40 - 0.65	0.030 max	0.030 max

All Weld Mechanical Properties:

YS (N/mm²)	UTS (N/mm²)	EL % (1=4d)
460 - 560	550 - 680	20 - 28

Sizes available and recommended currents (DC+)

SIZE	3/32 x 14"	1/8 x 14" / 18"	5/32 x 18"	3/16 x 18"
Current Condition	60 ~ 80	100 ~ 140	140 ~ 180	190 ~ 240

POLARITY: DCEP
DCEP: DC, Electrode Positive (reverse polarity) has the most weld penetration
WELDING POSITIONS: Flat, Horizontal, Overhead, Vertical-up and Vertical-down positions
USE LESS AMPS ON THIN METAL; MORE AMPS ON THICK METALS

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The above information is to be use as a guideline and is taken directly from the manufacturers Technical Data Sheet. If additional information is needed please contact (800) 692-5930