

LOW HYDROGEN IRON POWDER ELECTRODE FOR 1.0% Cr-0.5% Mo STEELS

EURO CRAFT B2

CODING:

AWS:E 8018-B2

CHARACTERISTICS:

EURO CRAFT B2 is a heavy coated low hydrogen iron powder type electrode suitable for chromium-molybdenum creep and heat resisting steels. The electrodes can be operated equally well on AC as well as DC+ in all welding positions. The weld metal contains about 1.25% chromium and 0.5% molybdenum.

NOTED FEATURES:

1. Specially designed to weld high tensile chromium-molybdenum creep and heat resisting steels.
2. Low spatter, easily removable slag and fine rippled bead.
3. Defect free radiographic quality weld metal.
4. Weld metal possesses good strength at elevated temp.
5. Good operating characteristics on AC as well as DC+

RECOMMENDED CURRENT RANGES:

SIZE mm		2.50 X 350	3.15 X 350	4.00 X 350	5.00 X 350
CURRENT-Amps	DC+/AC 70	60-100	100-140	140-190	200-260

TYPICAL CHEMICAL COMPOSITION OF WELD METAL

Element	C	Mn	Si	Mo	S	P	Cr
%	0.07	0.70	0.53	0.51	0.025	0.025	1.24

TYPICAL MECHANICAL PROPERTIES OF THE WELD METAL

UTS N/sq mm	% Elongation	CVN Impact value (J)
610-630	21-23	80-100(at +27°C)

SPECIAL INSTRUCTIONS:

1. For good welds, use absolutely dry electrodes.
2. Rebake electrodes @ 350°C for one hour, cool to 100°C and then maintain @ 100°C before use.
3. Preheating in the range 200-300C if necessary.
4. Post weld heat treatment of heating upto 650°C to relieve stresses and avoid cracking is essential.
5. Slow cooling is necessary after post weld heat treatment.