

CODING:**EURO JET B3****AWS A/SFA 5.5 E 9018-B3****CHARACTERISTICS:**

A medium heavy coated, hydrogen-controlled iron powder type, all position electrode with a deposition efficiency of approx 106% giving low alloy steel weld metal having approx 2.25%Cr, 1.0%Mo. Suitable for the welding of similar Cr-Mo steels such as German 10CrMo9 and 10CrSiMoV7. Welds are radiographically sound; creep resistance up to 600°C.

Redry the electrodes at 300°C for 1Hr for best results.

TYPICAL APPLICATIONS:

- Low alloy steel boilers and pipings operating at service temperatures upto 600°C.
- In oil refinery, thermal and chemical plants.
- Repair of high tensile steel castings.

TYPICAL ALL WELD METAL CHEMICAL COMPOSITION:

Element	C	Mn	Si	Cr	Mo	S	P
%	0.12 max	0.50-0.90	0.25-0.65	2.00-2.50	0.90-1.25	0.03 max	0.03 max

ALL WELD MECHANICAL PROPERTIES

	N/mm²
UTS	625-750
YS	540-670
Elongation(%) (l=4xd)	17-25

CURRENT CONDITIONS:

SIZE mm		2.50 X 350	3.15 X 350	4.00 X 350	5.00 X 350
CURRENT-Amps	AC/DC(+)	60-85	100-130	140-180	190-230

RECOMMENDED HEAT TREATMENT:

Preheat Temp.	:	150°C
Interpass Temp.	:	150°C to 250°C (depending on plate thickness)
Postheat Temp.	:	675°C TO 760°C

HIGH TEMPERATURE PROPERTIES:

Postheat Treatment	0.2% yield strength in N/mm ²		
	400°C	500°C	600°C
1/2hr/930°C/air	280	240	210
1hr/750°C/furnace	450	390	340