CLASSIFICATIONS:

EURO JET B9

AWS A5.5-96: E 9018-B9

PRODUCT DESCRIPTION:

Fully positional, highly basic, low hydrogen electrode for welding creep resisting steels. Excellent de-slag, restrike and general welder appeal. The addition of iron powder gives a recovery of ~110%.

APPLICATIONS:

Suitable for welding modified 9%Cr/Mo 0.2%V creep-resisting steels. The Vanadium and Nitrogen improve long term creep properties. Used mainly by the power engineering industry of headers, steam piping and turbine rotors.

TYPICAL ALL WELD METAL CHEMICAL COMPOSITION(Weight %):

Element	C	Mn	Si	S	P	Cr	Ni	Mo	V	N
min	0.08	0.80	0.20	-	-	8.0	0.10	0.85	0.18	0.03
max	0.12	1.20	0.30	0.020	0.020	9.5	0.20	1.10	0.25	0.07

ALL WELD MECHANICAL PROPERTIES

	N/mm^2
UTS	*675*
YS	549
Elongation on 5D(%)	21
Impact Energy CV @+20°C(j)	*70*

CURRENT CONDITIONS:

SIZE mm		2.50 X 350	3.20 X 350	4.00 X 350	5.00 X 350
CURRENT-Amps	AC(OCV70) DC+	70-90	90-130	130-180	160-220

STORAGE AND RE-DRYING:

Storage: It is recommended that the WB range of electrodes are stored in a dry heated store at a minimum temperature of 18°C and a maximum relative humidity of 60%. To avoid damage to the coatings no more than 6 cartons should be stacked on top of another.

Re-drying: Redry @ 350°C for 2 hours and then transfer to holding oven and hold @ 100-200°C or 50-100°C in heated quiver.