

ATOM ARC 7018-B2L AWS A5.5: E7018-B2LH4R

FEATURES

Atom Arc 7018-B2L is a 1 1/4 Cr - 1/2 Mo electrode with sensitivity extra low carbon content. The low carbon content in the weld metal is beneficial in reducing cracking of weldments. Atom Arc 7018-B2L is carefully engineered to produce a stable arc and good slag release when welding low-alloy steels in the categories of 0.5% Cr - 0.5% Mo, 1% Cr - 0.5% Mo, 1.25% Cr - 0.5% Mo steels. Most grades of these steels are used in power piping, boiler work, castings and forgings

TYPICAL MECHANICAL PROPERTIES

Stress Relieved 1 hr. @ 1275°F (691°C)

Yield Strength	74 ksi, 510 MPa
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Tensile Strength	88 ksi, 607 MPa
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Elongation in 2"	29%
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CLASSIFICATIONS AND APPROVALS

- AWS A5.5: E7018-B2LH4R
- ASME SFA 5.5

WELDING PROCESS

- SMAW (Stick)

WELD METAL ANALYSIS

C	0.04%
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Mn	0.8%
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Si	0.5%
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P	0.010%
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S	0.008%
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Cr	1.27%
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Mo	0.54%
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INDUSTRIES

- Pipeline
- Power Generation

ATOM ARC 7018-B2L continued

DEPOSITION TABLE

Diameter in (mm)	Optimal Current Amps	Current Range Amps	Deposition Rate lb/hr (kg/hr)	Efficiency %
3/32 (2.4)	90	70 - 100	1.7 (0.8)	66.3
1/8 (3.2)	120	90 - 160	2.6 (1.2)	71.6
	140	90 - 160	2.7 (1.2)	70.9
5/32 (4.0)	140	130 - 220	3.1 (1.1)	75
	170	130 - 220	3.8 (1.7)	73.5
3/16 (4.8)	200	200 - 300	4.9 (2.2)	76.4
	250	200 - 300	5.4 (2.4)	74.6
7/32 (5.6)	250	250 - 350	6.5 (2.9)	75
	300	250 - 350	7.2 (3.3)	74

PART NUMBER / PRODUCT INFORMATION

Part Number	Description	UPC
255183329	AA 7018-B2L 3/32X14X10#HS	662303018498
255183311	AA 7018-B2L 3/32X14X50#HS	662303018481
255181828	AA 7018-B2L 1/8X14X10#HS	662303018450
255181810	AA 7018-B2L 1/8X14X50#HS	662303018443
255185316	AA 7018-B2L 5/32X14X50#HS	662303018504
255183113	AA 7018-B2L 3/16X14X50#HS	662303018467
255187312	AA 7018-B2L 7/32X18X50#HS	662303018528