ATOM ARC 8018-B8 AWS A5.5: E8018-B8H4R

FEATURES

Atom Arc 8018-B8 is designed to weld 9% Cr - 1% Mo creep resisting steels such as ASTM A213-T9 and A335-P9. These steels are used in pressure vessels and piping for high temperature service.

TYPICAL MECHANICAL PROPERTIES

Stress Relieved 1 hrs @ 1375°F (746°C)	
Yield Strength	79 ksi, 545 MPa
Tensile Strength	98 ksi, 676 MPa
Elongation% in 2”	22%

CLASSIFICATIONS AND APPROVALS

- ASME SFA 5.5
- AWS A5.5: E8018-B8H4R

WELD METAL ANALYSIS

C	0.07%
Mn	0.8%
Si	0.3%
P	0.01%
S	0.01%
Cr	8.6%
Mo	1.0%
X-Factor	< 15

WELDING PROCESS

- SMAW (Stick)

INDUSTRIES

- Power Generation
- Pipeline
- Shipbuilding

ATOM ARC 8018-B8 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

PART NUMBER / PRODUCT INFORMATION		
Part Number	Description	UPC
255187908	AA 8018-B8 3/32X14X10#HS	662303063702
255187916	AA 8018-B8 1/8X14X10#HS	662303063719
255187924	AA 8018-B8 5/32X14X10#HS	662303063726
255187932	AA 8018-B8 3/16X14X10#HS	662303084837