

Classifications

EN ISO 3580-A:2008	: E Mo B 32 H10
EN ISO 3580-B:2008	: E 49 18-1M3 H10
AWS A5.5-06	: E7018-A1

Description

- Covering is low hydrogen, iron powder type for welding of alloys steel of 490MPa minimum yield point 0.5%Mo steel of pressure pipe, casting and general fabrication of pressure vessel.
- Preheat at 100~200°C and postheat treat at 620~680°C
- High deposition rate in all positions.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.06	0.49	0.72	0.015	0.011	0.02	0.03	0.53	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				20°C	0°C	
AWS A5.5	min. 390	min. 490	min. 22	≥ 47		
EN ISO 3580-A	min. 355	min. 510	min. 22			
Example	590	680	28	130	110	PWHT

* PWHT : 620°Cx1Hr

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amp. (A)	F V · OH	60-90 50-80	80-120 70-110	130-180 100-160	190-240 -	240-300 -

Approvals

CE