

SMAW Electrodes for Chromium-Molybdenum Low Alloy

GL98B3

AWS A5.5M E6218-B3
A5.5 E9018-B3
JIS Z 3223 DT2418

Product Features:

- Low hydrogen/ iron powder low hydrogen type covered electrode for low alloy heat resistant steel.
- Very low hydrogen contained in weld metal.
- All deposited weld metal contains approximately 2.25%Cr-1.0% Mo alloy elements, good for serving temperature $\leq 550^{\circ}\text{C}$.
- Good for RT examination, good mechanical properties.

Applications:

- Suitable for welding of 2.5%Cr-1.0% Mo grade steel such as JIS STBA24, A387 Gr.22.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Cr	Mo
0.07	0.49	0.66	2.28	1.05

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Post Weld Heat Treatment (PWHT) °C×1hr
590	671	22	690

Size (mm) & recommended welding parameters (A) AC or DC+

Diameter / Length	2.6/300	3.2/350	4.0/400	5.0/450
Flat position	60~90	90~140	150~200	190~240
Vertical / overhead position	50~80	80~110	120~150	140~190

Note:

- 300~350°C x 1hr baking prior to use.

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