

Product Data Sheet



BRAND NAME VJ 8018B6

AWS/ASME Class E8018B6

SPECIFICATION SFA A5.5

Features and Applications :

VJ 8018-B6 is a low hydrogen electrode for welding 5Cr-0.5Mo steels. It provides strong, heat-resistant welds with excellent creep strength up to 650°C and good toughness at low temperatures. Suitable for high-temperature applications in refineries and power plants. Preheat and interpass should be maintained during welding

CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	Max
C	0.06
Mn	0.85
Si	0.35
S	0.010
Cr	5.00
Mo	0.50

MECHANICAL PROPERTIES OF WELD METAL

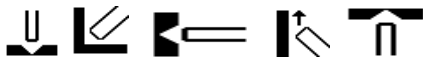
All Weld Metal - PWHT - 740°C/ 1 Hr	
Properties	Typical
YS (MPa)	510
UTS (MPa)	605
EI (%)	23

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Pcs)
	Min	Max	Qty / Pkt
Dia x Length			
2.50 x 350	70	100	150
3.15 x 450	100	130	100
4.00 x 450	140	180	70
5.00 x 450	180	240	45

CURRENT : AC/DC (+)

WELDING POSITION:



OTHER DATA:

Redrying: The electrodes should be redried at 250°C for 2 hour.