Product Data Sheet

BRAND NAME VJ 8018B8

AWS/ASME Class E8018-B8

SPECIFICATION SFA A5.5

Features and Applications :

VJ 8018B8 is a low hydrogen electrode producing 9Cr-1Mo welds with high creep strength up to 600°C and oxidation resistance to 700°C. Suitable for 7–10Cr-1Mo steels, it offers strong, corrosion-resistant, radiographic-quality welds for high-temperature applications.Application for Power plants, Oil refineries, Chemical and Petrochemical industries

CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	**Max**
C	0.07
Mn	0.65
Si	0.30
S	0.020
N	0.10
Cr	8.70
Mo	1.00

MECHANICAL PROPERTIES OF WELD METAL

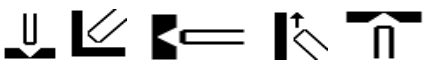
All Weld Metal - PWHT - 740^{0}C/ 1 Hr	
Properties	**Typical**
YS (MPa)	505
UTS (MPa)	610
El (%)	23

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Pcs)
Dia x Length	**Min**	**Max**	**Qty / Pkt**
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.