

Product Data Sheet



BRAND NAME VJ 9018B3

AWS/ASME Class E9018-B3

SPECIFICATION SFA A5.5

Features and Applications :

VJ 9018 B3 is a low-hydrogen, iron powder-coated electrode that ensures stable arcs and minimal spatter. It excellent creep resistance and radiographic-quality welds metal with 2.25% Cr – 1.0% Mo. Ideal for high-temperature applications such as boilers, pressure vessels, and oil field equipment, it also welds carbon or mild steel to 2.25% Cr – 1.0% Mo steels, providing durable, high-performance results.

CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	Max
C	0.05-0.12
Mn	0.90
Si	0.80
S	0.030
P	0.030
Cr	2.0-2.5
Mo	0.90-1.20

MECHANICAL PROPERTIES OF WELD METAL

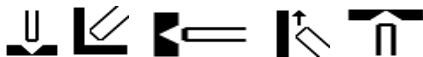
All Weld Metal - PWHT - 690°C/ 1 Hr	
Properties	Typical
YS (MPa)	530
UTS (MPa)	640-700
EI (%)	18-24

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.