

Product Data Sheet



BRAND NAME VJ 7018B2L

AWS E7018-B2L

SPECIFICATION SFA 5.5

Features and Applications :

VJ 7018-B2L is a low hydrogen, basic-coated electrode for all-position welding of 1.20% Cr – 0.5% Mo creep-resistant steels. It offers excellent mechanical properties, crack resistance, and toughness, making it ideal for high-temperature applications like boilers, pressure vessels, heat exchangers, and power plant piping.

CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	Max
C	0.04
Mn	0.80
Si	0.50
S	0.030
Cr	1.20
Mo	0.50

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - PWHT 690°C-1 Hr	
Properties	Typical
YS (MPa)	470
UTS (MPa)	582
El (%)	23

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Pcs)
	Min	Max	Qty / Pkt
2.50 x 350	70	100	150
3.15 x 450	90	140	100
4.00 x 450	140	190	70
5.00 x 450	190	250	45

CURRENT : AC/DC (+)

WELDING POSITION:



OTHER DATA:

Redrying: The electrodes should be redried at 250°C for 1 hour.