Product Data Sheet

BRAND NAME VJ 8018B2

AWS/ASME Class E8018-B2

SPECIFICATION SFA A5.5

Features and Applications :

VJ 8018B2 is a basic-coated, low-hydrogen electrode with iron powder, designed to deposit weld metal containing 1.25% Cr and 0.5% Mo. It offers excellent creep resistance at high temperatures and produces radiographic-quality welds. This electrode is ideal for welding 1.25% Cr – 0.5% Mo steels in applications such as boilers, pressure vessels, reactors, heat exchangers, and oil field equipment, both onshore and offshore. It is also suitable for welding carbon steel, mild steel, and similar alloy steels

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	1.0-1.5
Mo	0.40-0.65

MECHANICAL PROPERTIES OF WELD METAL

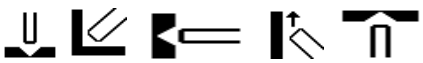
All Weld Metal - PWHT 690^{0}C - 1 Hr	
Properties	**Typical**
YS (MPa)	460-560
UTS (MPa)	550-650
El (%)	19-24

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	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 2 hour.