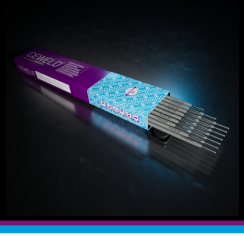


# CEWELD E 9018-B3

certilas® THE FILLER METAL SPECIALIST

**TYPE**

Basic electrode for creep resistant steel welding 2,25Cr-1Mo Alloy steels. (Type CrMo2 B , E9018-B3)

**APPLICATIONS**

CEWELD® E 9018-B3 is a basic electrode with Cr and Mo alloy for welding 10CrMo9-10 steels.
Recommended for welding in: Power generation industry
Petrochemical and chemical industry, boilers, Steam boilers and turbine construction.

**PROPERTIES**

CEWELD® E 9018-B3 is recommended for welding creep resistant steels working in temperatures up to 600°C. The Electrode have excellent welding properties with low spatter formation and very stable arc. Suitable for welding in all positions except vertical down. Excellent gap bridging for root welding. 118% recovery type for economic production of creep resistant steels and pressure-hydrogen-resistant 2¼Cr1Mo-steels.

**CLASSIFICATION**

| | |
|---|---|
| AWS | A 5.5: E 9018-B3 |
| EN ISO | 3580-A: E CrMo2 B 42 H5 |
| F-nr | 4 |
| FM | 3 |

**SUITABLE FOR**

**2,25% Cr, 1% Mo**
1.7015, 1.7131, 1.7147, 1.7258, 1.7262, 1.7276, 1.7281, 1.7337, 1.7350, 1.7357, 1.7375, 1.7379, 1.7380, 1.7382, 1.7383, 1.7385, 1.7707, 1.8075
10CrMo9.10, 12CrMo9-10, 10CrSiMoV7, 12CrSiMo8, 30CrMoV9, GS-18CrMo9.10, 15CrMoV5-10, 16CrMo4-4, 15CrMo5, 24CrMo5, 22CrMo4-4, GS-17CrMo5-5, 15Cr3, 16MnCr5, 20MnCr5, 10CrSiV7, G19CrMo9-10, 16CrMo9-3, 11CrMo9-10, 10CrMo11

ASTM: A 387 Gr. 22, A217 Grade WC9, A335 Gr. P22, A217 Gr. WC9, A182 F22, A182 T22, A1031 Gr.5015, A1031 Gr.5115, A1031 Gr.4820

**APPROVALS**

CE

**WELDING POSITIONS**


**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

| C | Si | Mn | P | S | Cr | Mo |
|---|---|---|---|---|---|---|
| 0.06 | 0.5 | 0.9 | 0.025 | 0.02 | 2.4 | 1 |

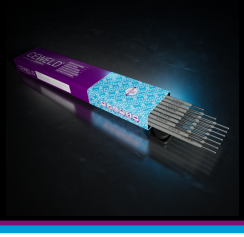
**MECHANICAL PROPERTIES**

| Heat Treatment | $R_{P0,2}$ (MPa) | Rm (MPa) | A5 (%) | Impact Energy (J) ISO-V RT | Hardness |
|---|---|---|---|---|---|
| 690°C±15°C 1h | 550 | 630 | 22 | 150 | HRc |

**REDRYING**

400°C / 1 hr

**GAS ACC. EN ISO 14175**



# CEWELD E 9018-B3

certilas® THE FILLER METAL SPECIALIST

E 9018-B3 2,5 X 350MM

| Packaging | KG/unit | EanCode |
|---|---|---|
| Can | 2,6 | 8720663400499 |

E 9018-B3 3,2 X 350MM

| Packaging | KG/unit | EanCode |
|---|---|---|
| Can | 2,6 | 8720663400529 |

E 9018-B3 4,0 X 450MM

| Packaging | KG/unit | EanCode |
|---|---|---|
| Can | 3,4 | 8720663400550 |