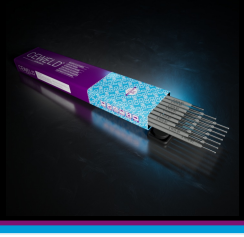


CEWELD E 9018-B3

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

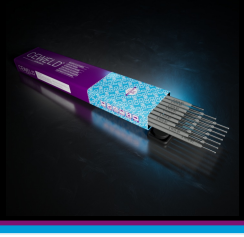
ALL WELD MECHANICAL PROPERTIES

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

REDRYING TEMPERATURE

400°C / 1 hr

GAS ACCORDING EN 14175



CEWELD E 9018-B3

certilas® THE FILLER METAL SPECIALIST

E 9018-B3 2,5 X 350MM

Type	KG/unit	EANCode
Can	2,6	8720663400499

E 9018-B3 3,2 X 350MM

Type	KG/unit	EANCode
Can	2,6	8720663400529

E 9018-B3 4,0 X 450MM

Type	KG/unit	EANCode
Can	3,4	8720663400550