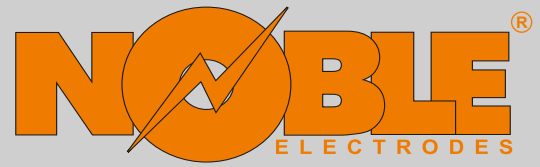


NOBLE - 8018-B2

Mild Steel Low Hydrogen type Radiographic
Quality Electrodes



CLASSIFICATION

AWS - A5.5: E8018-B2

Characteristics : **NOBLE - 8018-B2** is hydrogen controlled, heavy coated iron powder type electrode. It is suitable for radiographic quality welding of creep resisting and low alloy heat treatable steel. The weld metal deposit is of approximate 1.2% Cr & 0.5% Mo with excellent creep resistance at service temperature up to 550° C. Higher metal recovery gives excellent mechanical properties.

Applications : **NOBLE - 8018-B2** can be used in all position except vertical downward and for the welding of micro alloyed (Cr-Mo) steel used for super heater pipings in oil refinery, boiler & power house construction, railway class IV steels and part of earth moving equipments.

Mechanical Properties

Mechanical Tests	AWS Specifications
Yield Strength	460 N/mm ² (Min.)
Tensile Strength	550 N/mm ² (Min.)
Elongation	19 % (Min.)

* If Moist: Re-dry at 250°C For 2 Hrs.

Weld Metal Chemistry (%)

Elements	C	Mn	Si	P	S	Cr	Mo
Range	0.05 - 0.12	0.90 Max	0.80 Max	0.03 Max	0.03 Max	1.0 - 1.5	0.40 - 0.65

Packing Specifications & Current Condition

Size (mm)	Pkts. / Case	Pcs. / Pkt	Current (Amp.) AC (50V) DC (+)
2.50 x 350	04	200	60 - 85
3.15 x 450	04	125	100 - 140
4.00 x 450	04	70	140 - 180
5.00 x 450	04	55	180 - 230

“Noble – Characterized by all Excellent Qualities”