

### CLASSIFICATION

EN ISO 3580 : E CrMo 5 B 42  
AWS A5.5 : E8018-B6

### GENERAL DESCRIPTION

L-8018-B6 is a basic coated electrode particularly used for the welding of steels containing 5 % Cr and 0.5 % Mo. The weld metal has a crack resistance to operating temperatures up to 550°C. Since it is a low hydrogen electrode, the weld metal has a high creep resistance. It has about 110 % metal recovery. It is recommended to use the electrode in DC (+).

### APPROVALS

GOST, SEPRO, TSE

### CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Si	Mn	Cr	Mo
0.05	0.50	0.70	5.00	0.50

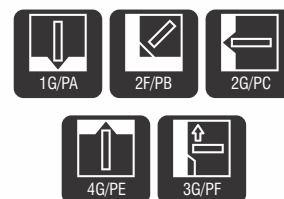
### MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength	: 400 N/mm <sup>2</sup>
Tensile Strength	: 580 N/mm <sup>2</sup>
Elongation (L=5d)	: 22 %
Impact (ISO-V)	: 80 J (+20°C)

### WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : DC ( + )

Diameter [ mm ]	Length [ mm ]	Current [ A ]	Electrode Weight [ g/100 pcs ]	Box Weight [ kg ] Quantity [ pcs/box ]	Export Box Box Weight [ kg ]
2.50	350	75 - 100	2300	4.6 / 200	5
3.25	350	90 - 140	3640	4.9 / 135	5



### APPLICATIONS AND MATERIALS TO BE WELDED

Power plant constructions; flange pipes used in petrochemical plants; forged cast parts, vapor production plants, preheaters and heaters, boiler and pressure vessels and pipe connections are among some application areas where AS DA-778 is used. It can also be used in welding similarly alloyed cementation steels, heat treatable steels and cast steels.

Part should be preheated to 300°C before welding and operating temperature during welding should not exceed 350°C.

	DIN	EN	Werkstoff Nr.
<b>Heat Resistant Steels</b>	15 CrMo 3	–	1.7205
	25 CrMo 4	–	1.7218
	15 CrMo 5	–	1.7262
	22 CrMo 4 4	–	1.7350
	12 CrMo 19 5	X12 CrMo 5	1.7362
<b>Cast Steels</b>	GS-17 CrMo 5 5	G-17 CrMo 5 5	1.7357
	GS-25 CrMo 4	G-25 CrMo 4	1.7218
	GS-22 CrMo 5	G-22 CrMo 5	1.7252
	GS-22 CrMo 5 4	G-22 CrMo 5 4	1.7354
	GS-12 CrMo 19 5	G-X 12 CrMo 19 5	1.7363
<b>Cementation Steels</b>	15 Cr 3	–	1.7015
	–	16 MnCr 5	1.7131
	–	20 MnCr 5	1.7147

**Liability** : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.  
**Fumes** : Consult information on Welding Safety Sheet, available upon request.