



# CEWELD E 8018-B2

**TYPE** Basic stick electrode for welding similar Cr-Mo alloyed steels. ( Type 1Cr-0,5Mo ; E8018-B2 )

**APPLICATIONS** CEWELD® E 8018-B2 is a basic stick electrode for welding joints made of similar Cr-Mo alloyed steels.  
It is used for welding in: Steam plant construction, plant and tank construction, waste plant construction, boiler plant construction, pipe production, heat exchanger production, etc.

**PROPERTIES** The basic coating of CEWELD® E 8018-B2 guarantees a low content of diffusible hydrogen in the weld metal (HD < 5 ml/100 g ) and an output of 120 %.  
It is suitable for welding medium alloyed steels and shows resistance at high temperatures up to 550 °C in the long-term range

**CLASSIFICATION**

AWS	A 5.5: E 8018-B2
EN ISO	3580-A: E CrMo1 B 42 H5
F-nr	4
FM	3

**SUITABLE FOR** **Typ 1Cr0,5Mo, ISO 15608: ~5,1**  
1.7205, 1.7218, 1.7225, 1.7228, 1.7254, 1.7258, 1.7262, 1.7335, 1.7337, 1.7350, 1.7354, 1.7357, 1.7728  
13CrMoV42, 13CrMo4-4, 13CrMo4-5, 15CrMo3, 15CrMo5, 13CrMoV42, 15Cr3, 16MnCr5, 20MnCr5, 15CrMo5, 24CrMo5, 25CrMo4, GS-22CrMo5, GS-22CrMo54, GS 17CrMo5-5, 16CrMoV4, 42CrMo4, 42CrMo4V, 41CrMo4V,  
ASTM A 182 Gr. F11 / F12; A 193 Gr. B7; A 213 Gr. T12; A 217 Gr. WC6; A 234 Gr. WP11; A335 Gr. P11, P12; A 336 Gr. F11, F12; A 426 Gr. CP12 ; A 199; A200; A 387 Gr A11 / 12

**APPROVALS** CE

**WELDING POSITIONS**



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

C	Si	Mn	P	S	Cr	Mo
0.09	0.5	0.8	0.025	0.02	1.2	0.5

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT	-20°C	
690°C±15°C 1h	520	610	23	120	60	HRc

**REDRYING** 400°C / 1 hr

**GAS ACC.** EN ISO 14175



# CEWELD E 8018-B2

E 8018-B2 2,5 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720682050859

E 8018-B2 3,2 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720682050866

E 8018-B2 4,0 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,4	8720682050873