



## RASI E 8018 - B2

premium

BASIC COATED LOW HYDROGEN ELECTRODES

### TECHNICAL SPECIFICATION SHEET

#### CHARACTERISTICS

RASI E 8018 - B2 is a heavy basic coated, all position, low hydrogen type electrode deposit weld metal of 1 Chrome and 1/2 Moly with excellent creep and heat resisting properties at elevated temperature upto 550oC. It gives radio graphic quality weld.

#### APPLICATIONS

Suitable for welding, boiler and refinery, Chrome moly plates and pipe lines. For Welding of 1 Cr and 1/2 Mo, and also suitable for welding of ASTM A 182, A 2 14, A 335, A 387 and etc.

#### CLASSIFICATIONS

IS 1395 E - 55BB226Fe  
AWS A5.5 E - 8018-B2

#### CHEMICAL COMPOSITION OF ALL WELD METAL

Carbon - 0.08%	Silicon - 0.35%
Manganese - 0.65%	Sulfur - 0.02%
Phosphorus - 0.025%	Cr - 1.25%
Mo - 0.55%	

Note: Single Values shown above are maximum

#### MECHANICAL PROPERTIES OF ALL WELD METAL

Tensile Strength (N/mm<sup>2</sup>) - 600  
Yeild Strength (N/mm<sup>2</sup>) - 520  
Elongation % - 22% MIN.

#### WELDING CURRENT : DC± / AC 50 V

Ø 2.50 mm - 60 - 100 Amps  
Ø 3.15 mm - 100 - 140 Amps  
Ø 4.00 mm - 140 - 190 Amps  
Ø 5.00 mm - 190 - 240 Amps.  
Ø 6.30 mm - 240 - 300 Amps.

**\*FOR APPROVALS AND CERTIFICATIONS KINDLY CONTACT :- [info@rasielectrodes.com](mailto:info@rasielectrodes.com)**

storage - Store in warm and dry place. If damped re dry at 300°C for 1 hour.

\*All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

[www.rasielectrodes.com](http://www.rasielectrodes.com)

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