



MAC TRODE E6818-B2

■ **Description & Applications:**

A superior versatile low hydrogen electrode Ni Cr type. AWS E8018-B2 which uses a silicon free, low nitrogen, high purity C:Mn core wire with a moisture resistant chemically basic flux with a controlled iron powder addition. Recommended for resistance to hydrogen attack up to 330°C and corrosive effects of processing high S crude oil up to 450°C and for prolonged elevated temperature service up to 550°C with reasonable degree of corrosion resistance in superheated stream.

■ **Related Specification:**

AWS E8018-B2

■ **Typical All Weld Metal Chemical Analysis %:**

C	Si	Mn	P	S	Cr	Mo
0.07	0.30	0.85	0.007	0.008	1.25	0.55

■ **Typical All Weld Metal Mechanical Properties:**

<u>As Welded</u>		<u>Minimum</u>	<u>Typical</u>
Tensile Strength	N/mm ²	550	715
0.2% Proof Stress	N/mm ²	460	640
Elongation on 4d	%	19	24
Reduction of area	%	-	75
Impact Energy -10°C	Joules	-	100

■ **Current:**

DC +/- AC (OCV 70) Min

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm	6.00mm
70-90	90-130	130-180	160-220	250-300

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 150°C before use.