



## MAC TRODE E6918-B3

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■ **Description & Applications:**

A superior versatile low hydrogen electrode nickel chromium molybdenum type. AWS E9018-B3 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. Smooth arc low spatter, easy strike and restrike. Recommended for prolonged elevated temperatures up to 600°C associated with steam generated power plants, e.g. turbines, casting, valve bodies, boiler super heaters and pipes.

■ **Related Specification:**

AWS E9018-B3

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

C	Si	Mn	P	S	Cr	Mo
0.06	0.30	0.85	0.007	0.008	2.25	1.05

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

<u>As Welded</u>		<b>Min</b>	<b>Typical</b>
Tensile Strength	N/mm <sup>2</sup>	630	700
0.2% Proof Stress	N/mm <sup>2</sup>	540	620
Elongation on 4d	%	15	19
Reduction of area	%	-	65
Impact Energy -10°C	Joules	-	80

■ **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.