

Atom Arc 8018-B3L



Atom Arc 8018-B3L electrodes contain 2 1/4% Cr and 1% Mo alloy additions with low carbon content. The electrode is designed for welding 2 1/4% Cr - 1% Mo steels. The rod operates with a very stable arc and minimal spatter. The low carbon analysis of the weld metal contributes to its crack resistance. The addition of Cr and Mo provide for the excellent creep and stress rupture properties of weldments subjected to elevated temperature service.

Classifications	AWS A5.5 : E8018-B3L H4R ASME SFA 5.5
Industry	Mobile Equipment Pipeline Power Generation

Welding Current	AC or DC+
Coating Type	Low-hydrogen iron powder

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Cr	Mo	X-bar
0.04	0.70	0.40	0.015	0.017	2.30	1.10	<15

Deposition Data

Diameter	Optimal Amps	Current	Deposition Rate	Deposition Efficiency %
3.2 mm (1/8 in.)	120 A	90-160 A	1.2 kg/h (2.6 lb/h)	71.6 %
3.2 mm (1/8 in.)	140 A	90-160 A	1.2 kg/h (2.7 lb/h)	70.9 %
2.4 mm (3/32 in.)	90 A	70-100 A	0.8 kg/h (1.7 lb/h)	66.3 %
4.0 mm (5/32 in.)	140 A	130-220 A	1.1 kg/h (3.1 lb/h)	75 %
4.0 mm (5/32 in.)	170 A	130-220 A	1.7 kg/h (3.8 lb/h)	73.5 %