



## Atom Arc 8018-B6



Atom Arc 8018-B6 is designed to weld 5% Cr - 1/2% Mo creep resisting steels such as ASTM A387 Grade 5, A213-T5 and A335-P5. These steels are normally used in pressure vessels and piping for high temperature service.

<b>Classifications</b>	AWS A5.5 : E8018-B6 H4R ASME SFA 5.5
<b>Industry</b>	Pipeline Power Generation Ship/Barge Building

<b>Welding Current</b>	AC or DC+
<b>Coating Type</b>	Low-hydrogen iron powder

### Typical Weld Metal Analysis %

C	Mn	Si	S	P	Cr	Mo	X-bar
0.07	0.70	0.50	0.009	0.013	5.30	0.60	< 15

### Deposition Data

Diameter	Optimal Amps	Current	Deposition Rate	Deposition Efficiency %
2.4 mm (3/32 in.)	90 A	70-100 A	0.8 kg/h (1.7 lb/h)	66.3 %
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 %
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 %