

**Stick electrode for 1~1.25%Cr-0.5%Mo steel**

**Features:** ■ Applied for ASTM A387 Gr.11, Gr.12 and equivalents

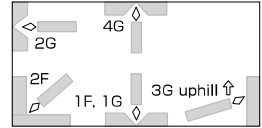
**Welding Positions:**

**Classification:** AWS A5.5 E8018-B2

**Redrying Conditions:** 325~375°Cx1h

**Identification color:** 1st Black, 2nd Yellowish green

**Polarity:** AC, DCEP

**Packaging data**

| $\phi$ mm | Length mm | kg/pack | kg/carton | g/piece | carton mm        |
|-----------|-----------|---------|-----------|---------|------------------|
| 2.6       | 300       | 2       | 20        | 19      | 170W, 120H, 330L |
| 3.2       | 400       | 5       | 20        | 38      | 170W, 120H, 430L |
| 4.0       | 450       | 5       | 20        | 69      | 170W, 120H, 480L |
| 5.0       | 450       | 5       | 20        | 106     | 170W, 120H, 480L |
| 6.0       | 450       | 5       | 20        | 154     | 170W, 120H, 480L |

**Composition (all-weld metal mass%)**

|           | Typical (AC) | Guaranty <sup>a</sup> |
|-----------|--------------|-----------------------|
| <b>C</b>  | 0.07         | 0.05~0.12             |
| <b>Si</b> | 0.73         | 0.80                  |
| <b>Mn</b> | 0.78         | 0.90                  |
| <b>P</b>  | 0.01         | 0.03                  |
| <b>S</b>  | <0.01        | 0.03                  |
| <b>Cr</b> | 1.31         | 1.00~1.50             |
| <b>Mo</b> | 0.54         | 0.40~0.65             |

Note: <sup>a</sup> Single values are maximum.

**Welding parameters (A)**

| $\phi$ mm | 1F, 1G, 2F, 2G | 3G uphill, 4G |
|-----------|----------------|---------------|
| 2.6       | 65~95          | 60~90         |
| 3.2       | 90~130         | 80~120        |
| 4.0       | 135~185        | 110~170       |
| 5.0       | 190~250        | -             |
| 6.0       | 250~320        | -             |

**All-weld mechanical properties**

|                     | Typical (AC) | Guaranty |
|---------------------|--------------|----------|
| <b>0.2%YS (MPa)</b> | 590          | 462min.  |
| <b>TS (MPa)</b>     | 690          | 552min.  |
| <b>El on 4d (%)</b> | 26           | 19min.   |
| <b>IV 0°C (J)</b>   | 70           | -        |
| <b>PWHT (°C×h)</b>  | 690x1        | 690±15x1 |

**Approvals**

| LR | MG |
|----|----|
|----|----|