



# S. R. Industries

## STAR ARC E8018-B2

**E8018-B2** welding electrode is for higher strength steels with tensile strengths greater than 80,000 pounds. The coating is specially formulated to resist moisture pick-up under conditions of high heat and humidity. This electrode offers resistance to moisture reabsorption which helps prevent hydrogen cracking and aids in elimination of starting porosity.

**Typical Applications :** fabrication and maintenance of boilers and associated piping.

<b>AWS Class :</b> E8018-B2 H4R	<b>Classification :</b> AWS A5.5/A5.5M:2006
<b>Alloy:</b> E8018-B2	<b>ASME SFA</b> A5.5
<b>Welding Position:</b> F, V, OH, H	<b>Current:</b> AC-DCEP
<b>Tensile Strength, kpsi:</b>	80
<b>Yield Strength, kpsi:</b>	67
<b>Elongation in 2" (%):</b>	19

**Typical Wire Chemistry as per AWS A5.5 (single values are maximum)**

<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>P</b>	<b>S</b>	<b>Cr</b>	<b>Mo</b>
0.05-0.12	0.90	0.80	0.03	0.03	1.00-1.50	0.40-0.65

<b>Typical Welding Parameters</b>					
<b>Diameter</b>		<b>Process</b>	<b>Volt</b>	<b>Amps (flat)</b>	<b>Amps (V/OH)</b>
<b>in</b>	<b>(mm)</b>				
3/32	(2.4)	SMAW	21-25	65-50	65-75
1/8	(3.2)	SMAW	21-25	90-110	80-95
5/32	(4.0)	SMAW	21-26	135-160	120-140
3/16	(4.8)	SMAW	22-26	160-210	140-160

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