

AI-0180

Specifications

AS/NZS 1553.2 : E5518-B2 H5R

AWS/ASME A5.5 : E 8018-B2 H4

EN ISO 3580-A : E CrMo1B 4 2 H5

Description and Applications

Universal basic coated electrode for welding of high temperature steels. Suitable for applications up to 550°C.

Used for welding Chrome Moly pipes, plates and castings. Used in the petrochemical, refineries, paper and power industries. Can also be used to weld Chrome Moly to Carbon Steel and for case hardening steels.

Typical Weldmetal Analysis

C	Mn	Cr	Fe	P
0.07	0.6	1.3	Bal	0.015

Mechanical Properties of Weldmetal

	As Welded
Tensile Strength	510-610MPa
Yield Strength (0.2%)	>420Mpa
Elongation	>24% (4d)
Charpy Impact KV(J)°C	20°C >160
	-20°C >100
	-40°C >47

Welding Parameters

Diameter (mm)	Current type	Amps
2.5	DC /AC	80
3.25	DC /AC	120
4.0	DC /AC	140
5.0	DC /AC	180

MIG wire: Various options available

Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position, (3G, 3F, 5G up) Vertical Position Up, (3G, 3F, 5G down) Vertical position down

Disclaimer

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy.

All figures subject to change without notice. Batch analysis is available for all products sold. Should you require any further information, please contact us at sales@alloysint.com.au



ALLOYS INTERNATIONAL PTY LTD

25 Raymond Road Laverton North Victoria 3026

Telephone: +61 3 8368 2222 | Facsimile: +61 3 8368 2200

ABN 53 112 712 286

sales@alloysint.com.au | www.alloysint.com.au