

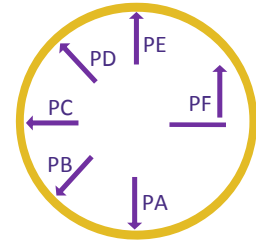
Applications

- TSC 8018-B2 is an iron powder and low hydrogen type stick electrode for the use of low alloy heat-resistant steel(1.25%Cr-5%Mo)

Features

- Good mechanical properties
- Good creep resistance

Welding Position



Typical Chemical Properties of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Mo
0.072	0.46	0.70	0.013	0.009	1.29	0.56

Typical Mechanical Properties of All-Weld Metal

Ys MPa	TS MPa(lbs/in ²)	EL (%)	I.V J/°C
545	628	28	175/RT

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	350 (14)	450 (18)	450 (18)	450 (18)
F	55-90	90-130	130-190	190-240
V-up, OH	50-80	80-120	120-170	

Current

AC or DC ±

Redrying Conditions

300~350°C (572~662°F) X 0.5~1hr

Notes on Usage

- Because of excessive heat input, the impact value tends to be lower. Therefore, choose proper heat input.
- Preheat treatment before welding at 160-220°C and try to keep low hydrogen situation during whole welding process.
- Keep short arc length when welding.

Packing Details

4Kg Pack / 16 Kg Ctn (Vacuum Packing)