



E8018-B6 DATA SHEET

Pinnacle Alloys E8018-B6

AWS CLASS E8018-B6 H4R

CODE AND SPECIFICATION DATA:

AWS A5.5 ASME SFA 5.5; UNS W50218

DESCRIPTION:

Pinnacle Alloys E8018-B6 are low-hydrogen electrodes producing weld metal that nominally contains 5% Cr and 0.5% Mo. They are designed to produce weld metal for high-temperature service and for matching the properties of some chromium-molybdenum base materials such as ASTM A387 Grade 5. Since all chromium-molybdenum electrodes produce weld metal which will harden in still air, both preheat and PWHT are required for most applications. The coating is specially formulated to reduce moisture pick-up, minimizing hydrogen cracking and starting porosity. This electrode strikes and re-strikes easily and provides a stable arc that is easy to control. It has quick and easy slag removal, which reduces clean up time. The low spatter level improves weld bead appearance and lends itself to higher deposition. Pinnacle Alloys E8018-B6 is primarily used for the petrochemical and petroleum industries, but is also an excellent choice for tubes, tube sheets, and plate steels for high pressure hydrogen service.

TYPE OF CURRENT: Direct Current Electrode Positive (DCEP)**DIAMETERS:** 3/32", 1/8", 5/32", 3/16"**STORAGE & RECONDITIONING:** After opening, store in an oven controlled at 250°F to 300°F to ensure a low hydrogen weld deposit. If the electrode has been exposed to the atmosphere for extended periods of time, place in 250°F oven and slowly increase temperature to 600°F; bake for one hour at 600°F.**WELDING POSITIONS:** All positions
3/16" is recommended for use in flat and horizontal positions only**TYPICAL DIFFUSIBLE HYDROGEN BY GAS CHROMATOGRAPHY:** 3.2 ml/100gwww.pinnaclealloys.com9384 Wallisville Road • Houston, Texas 77013 • 1-800-856-9353 • (713) 688-9353 • Fax (713) 688-6985
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AN ISO 9001:2015 COMPANY
CERTIFICATE NO.: C755336

TYPICAL DEPOSIT COMPOSITION:

	AWS Spec	Weld Metal Analysis (%)
Carbon (C)	0.05-0.10	0.05
Chromium (Cr)	4.00-6.00	4.80
Manganese (Mn)	1.00	0.80
Molybdenum (Mo)	0.45-0.65	0.48
Nickel (Ni)	0.40	0.07
Phosphorus (P)	0.03	0.01
Silicon (Si)	0.90	0.30
Sulfur (S)	0.03	0.01

NOTE: Single values are maximums.

TYPICAL MECHANICAL PROPERTIES:

	AWS Spec (min)	SR 1 HR. @ 1375°F
Ultimate Tensile Strength	80,000 psi (550 MPa)	87,000 psi (603 MPa)
Yield Strength	67,000 psi (460 MPa)	72,000 psi (499 MPa)
Percent Elongation in 2"	19%	24%

TYPICAL WELDING PARAMETERS:

Diameter	Type of Current	Amperage	Amperage Range	Voltage Range
3/32"	DCEP	95	70-110	Variable
1/8"	DCEP	140	90-160	Variable
5/32"	DCEP	190	130-210	Variable
3/16"	DCEP	250	200-290	Variable

NOTE: Optimum conditions are in boldface type. For out of position welding, decrease amperage by 15%. These values were calculated using optimum parameters and DCEP polarity. Allowance made for 2" stub loss. Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of steel being welded.

NOTICE: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for the use in the field. The manufacturer disclaims any warranty of merchantability of fitness for any particular purpose with respect to its products.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CRF 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.

Pinnacle Alloys SDS sheets may be obtained on the website below.