

AK E9018-B3

Description: E9018-B3 is a great electrode for welding higher strength piping, castings and forgings. The coating is specially formulated to resist moisture pick-up under conditions of high heat and humidity. E9018-B3 electrode offers resistance to moisture reabsorption which helps prevent hydrogen cracking and aids in elimination of starting porosity.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	V
Requirement	0.05-0.12	0.80	0.9	0.030	0.030	—	0.90-1.20	2.0-2.5	
Actual Result	0.063	0.30	0.61	0.010	0.011	—	0.96	2.36	

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥620	≥530	≥ 17	≥54J
Actual Result	680	580	22	90 90 92