

COATED ELECTRODES

Oxford Alloy® 8018-B6

AWS E8018-B6 • Chrome Moly

Key Features

- ❖ Designed to weld 5% Chrome -1/2% Molybdenum creep resisting steels such as ASTM A387 Grade 5, A213-T5 and A335-P5.
- ❖ Typical applications include power generation, pressure vessels, petrochemical, and process piping.

Conformances

AWS ASME SFA 5.5
E8018-B6
UNS W50218



Chemical Composition - As required per AWS 5.5						
C	Mn	Si	P	S	Cr	Ni
0.05-0.10	1.0 max	0.90 max	0.03 max	0.03 max	4.0-6.0	0.40 max
Mo						
0.45-0.65						

Mechanical Properties - As required by AWS 5.5			
	Tensile Strength MPa (kst)	Yield Strength MPa (kst)	Elongation %
AWS Requirements	550 (80) min	460 (67) min	19 min
Typical Results - As welded	670 (97)	590 (97)	25

Typical Welding Parameters					
Diameter		Process	Volt	Amps (flat)	Amps (V/OH)
in	(mm)				
3/32	(2.4)	SMAW	21-25	65-80	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

Diameters & Packaging					
Oxford Alloys USA			Oxford Alloys Asia Pacific		
Diameter (in)	Length (in)	Packaging (lbs)	Diameter (mm)	Length (mm)	Packaging (kgs)
3/32"	12	10 lb tube 30 lb carton	2.6	300	4 kg tube 12 kg carton
1/8"	14	10 lb tube 30 lb carton	3.2	350	5 kg tube 15 kg carton
5/32"	14	10 lb tube 30 lb carton	4.0	350	5 kg tube 15 kg carton
3/16"	14	10 lb tube 30 lb carton	5.0	350	5 kg tube 15 kg carton

Actual test results may vary. Refer test result disclaimer on page 160.