



# LKE-9018-B3

LINKWELD ALLOYS INC.

AWS	A5.5 E9018-B3
EN	EN1599 E CrMo2 B 3 2
JIS	Z3223 DT2418

## Characteristics:

LKE-9018-B3 is an iron powder low hydrogen type electrode for low alloy heat resistance steel. The weld metal contains 2.25%Cr-1%Mo which the service temperature is at 550 °c. Good creep rupture strength also can be obtained at high temperature.

## Applications:

It is suitable for welding of piping steels (STPA24, A335-P22), boilers (STBA24), heat exchanger pipes (A182-F22, A336-F22)

## Notes on Usage:

- 1.Dry the electrodes at 350-400 °c for 60 minutes before use.
- 2.Keep the arc as short as possible.

## Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Cr	Mo
0.080	0.69	0.70	0.013	0.011	2.32	1.07

## Typical mechanical properties of weld metal

YP N/mm <sup>2</sup>	TS N/mm <sup>2</sup>	EL %	PWHT
620	725	24	690°c x1hr

## Welding position:



## Sizes and recommended current range (AC or DC <+> )

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	400	400
Amps	F	90-140	140-190	190-240
	V&OH	80-120	120-160	-
Weight per pack(kg)		5	5	5
Weight per carton (kg)		20	20	20