



# CEWELD E 9018-B3

**TYPE** Basic electrode for creep resistant steel welding 2,25Cr-1Mo Alloy steels. (Type CrMo2 B , E9018-B3)

**APPLICATIONS** CEWELD® E 9018-B3 is a basic electrode with Cr and Mo alloy for welding 10CrMo9-10 steels. Recommended for welding in: Power generation industry  
Petrochemical and chemical industry, boilers, Steam boilers and turbine construction.

**PROPERTIES** CEWELD® E 9018-B3 is recommended for welding creep resistant steels working in temperatures up to 600°C. The Electrode have excellent welding properties with low spatter formation and very stable arc. Suitable for welding in all positions except vertical down. Excellent gap bridging for root welding. 118% recovery type for economic production of creep resistant steels and pressure-hydrogen-resistant 2¼Cr1Mo-steels.

**CLASSIFICATION**

AWS	A 5.5: E 9018-B3
EN ISO	3580-A: E CrMo2 B 42 H5
F-nr	4
FM	3

**SUITABLE FOR** **2,25% Cr, 1% Mo**  
1.7015, 1.7131, 1.7147, 1.7258, 1.7262, 1.7276, 1.7281, 1.7337, 1.7350, 1.7357, 1.7375, 1.7379, 1.7380, 1.7382, 1.7383, 1.7385, 1.7707, 1.8075  
10CrMo9.10, 12CrMo9-10, 10CrSiMoV7, 12CrSiMo8, 30CrMoV9, GS-18CrMo9.10, 15CrMoV5-10, 16CrMo4-4, 15CrMo5, 24CrMo5, 22CrMo4-4, GS-17CrMo5-5, 15Cr3, 16MnCr5, 20MnCr5, 10CrSiV7, G19CrMo9-10, 16CrMo9-3, 11CrMo9-10, 10CrMo11

ASTM: A 387 Gr. 22, A217 Grade WC9, A335 Gr. P22, A217 Gr. WC9, A182 F22, A182 T22, A1031 Gr.5015, A1031 Gr.5115, A1031 Gr.4820

**APPROVALS** CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	P	S	Cr	Mo
0.06	0.5	0.9	0.025	0.02	2.4	1

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT		
690°C±15°C 1h	550	630	22	150		HRc

**REDRYING** 400°C / 1 hr

**GAS ACC. EN ISO 14175**



# CEWELD E 9018-B3

E 9018-B3 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	2,6	8720663400499

E 9018-B3 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,6	8720663400529

E 9018-B3 4,0 X 450MM

Packaging	KG/unit	EanCode
Can	3,4	8720663400550