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| 标准 | AWS A5.5 | EN ISO 18275-A | GB/T5118 |
| 标号 | E9018-G | E55 2 Z B 42 H5 | E6218-G |

特性及应用范围

- 碱性药皮镍钼铬合金钢焊条，熔敷金属具有极高的纯净度
- 焊条含氢量 < 4ml/100 g (HD)，通过落锤试验检测，焊接性优良；
- 适用于核反应堆设备、化工、高压容器及锅炉制造焊接，及StE 500级别以下的细晶粒结构钢，核电常规岛中防止流动加速腐蚀的WB36S1控Cr钢的焊接。

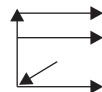
适用母材

20MnMoNi55, 22NiMoCr37, AWS A 508 CI 2, AWS A 533 CI 1Gr.B, 15NiCuMoNb 5 S 1, GS-18 NiMoCr 37, 11NiMoV 53 (Welmonil 43), 12MnNiMo 55 (Welmonil 35), StE 420 - StE 500, WStE 420 - WStE 500, WB 36S1, WB36CN1.

| | | | | | | | | | | | |
|-------------------|-----|----------|-----------|-----------|----------|----------|-----------|-----------|-----------|----------|-----------|
| 纯熔敷金属化学成分 (Wt. %) | | C | Si | Mn | P | S | Cr | Ni | Mo | V | Cu |
| | AWS | - | - | - | - | - | - | - | - | - | - |
| | EN | - | - | - | - | - | - | - | - | - | - |
| | 典型值 | 0.05 | 0.13 | 0.98 | 0.007 | 0.006 | 0.28 | 0.99 | 0.43 | 0.01 | 0.08 |

| | | | | | | | |
|--------------------------|---------|--------------|-------------------------------|----------------------------|--------------------------|--------------------------|-------|
| 全焊缝金属机械性能 (根据 AWS B4.0M) | | 焊后热处理 (°C/h) | R_{p0.2} (MPa) | R_m (MPa) | A₄ (%) | K_v (J) | |
| | | | | | | +20°C | -20°C |
| | AWS | - | ≥530 | ≥620 | ≥17 | - | - |
| | EN | - | ≥550 | 610-780 | ≥18 | - | ≥47 |
| | 典型值 | 620/3 | 680 | 735 | 24 | 170 | 120 |
| | 620/9 | 620 | 690 | 27 | 200 | 160 | |
| 保证值 | 620/3-9 | ≥530 | ≥620 | ≥21 | 100 | ≥47 | |

使用规范

适用焊接位置  电流极性: DC+
 烘干说明: 使用前需300 ~ 350°C烘干2小时。

| | | | | |
|------|-------|---------|--------|-------------|
| 供货标准 | 产品编号 | 规格 (mm) | 单位包装形式 | 单位包装重量 (Kg) |
| | 73244 | 2.5×300 | 箱 (3罐) | 10.8 |
| | 73245 | 3.2×350 | 箱 (3罐) | 12.9 |
| | 73044 | 4.0×350 | 箱 (3罐) | 13.2 |
| | 72626 | 5.0×450 | 箱 (3罐) | 17.1 |

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|--------------------------|-----------------|-----------------------|-----------------|
| Specification Clas. Code | AWS A5.5 | EN ISO 18275-A | GB/T5118 |
| | E9018-G | E55 2 Z B 42 H5 | E6218-G |

Properties & Application

- Basic-covered NiMoCr-alloyed electrode with a weld metal of special metallurgical purity
- Very low H2 content < 5ml/100g (HD), NDT tested, good weld ability..
- Used preferably for welding steels in the construction of reactor construction, boilers and pressure vessels; for fine-grained structural steels up to S500Q; and for WB36S1 steel in the reactor construction.

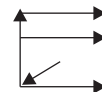
Base Metals

20MnMoNi55, 22NiMoCr37, AWS A 508 CI 2, AWS A 533 CI 1Gr.B, 15NiCuMoNb 5 S 1, GS-18 NiMoCr 37, 11NiMoV 53 (Welmonil 43), 12MnNiMo 55 (Welmonil 35), StE 420 - StE 500, WStE 420 - WStE 500, WB 36S1, WB36CN1.

| | | | | | | | | | | | |
|--|---------|----------|-----------|-----------|----------|----------|-----------|-----------|-----------|----------|-----------|
| Chemical Composition of Undiluted Weld Metal (Wt. %) | | C | Si | Mn | P | S | Cr | Ni | Mo | V | Cu |
| | AWS | - | - | - | - | - | - | - | - | - | - |
| | EN | - | - | - | - | - | - | - | - | - | - |
| | Typical | 0.05 | 0.13 | 0.98 | 0.007 | 0.006 | 0.28 | 0.99 | 0.43 | 0.01 | 0.08 |

| | | | | | | | |
|--|---------|-------------|-------------------------------|----------------------------|--------------------------|--------------------------|-------|
| Mechanical Properties of All Weld Metal (According to AWS B4.0M) | | PWHT (°C/h) | R_{p0.2} (MPa) | R_m (MPa) | A₄ (%) | K_v (J) | |
| | | | | | | +20°C | -20°C |
| | AWS | - | ≥530 | ≥620 | ≥17 | - | - |
| | EN | - | ≥550 | 610-780 | ≥18 | - | ≥47 |
| | Typical | 620/3 | 680 | 735 | 24 | 170 | 120 |
| | 620/9 | 620 | 690 | 27 | 200 | 160 | |
| Guarantee | 620/3-9 | ≥530 | ≥620 | ≥21 | 100 | ≥47 | |

Operating Data

Welding Position  Polarity: DC+
 Instruction for Redrying: Redry for 2 h at 300-350°C before using.

| | | | | |
|----------------|-------------|-----------|----------------|---------|
| Size & Packing | Product No. | Size (mm) | Pack | Kg/pack |
| | 73244 | 2.5×300 | Carton (3 Can) | 10.8 |
| | 73245 | 3.2×350 | Carton (3 Can) | 12.9 |
| | 73044 | 4.0×350 | Carton (3 Can) | 13.2 |
| | 72626 | 5.0×450 | Carton (3 Can) | 17.1 |