

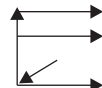
标准	AWS A5.5	EN ISO 3580-A	GB/T5118
标号	E8018-B2H4R	E CrMo1 B 42 H5	E5518-1CM

- 特性及应用范围**
- 碱性、超低氢、铁粉电焊条；
 - 专为气化炉、石化设备等制造中1.25Cr-0.5Mo低合金钢设计；
 - 焊接性优良，冷裂纹敏感性较低，适用于全位置焊接；
 - 其焊缝金属在500℃以下具备良好的耐高温性能，在570℃以下具备良好的抗蠕变性能；
 - 焊缝纯度高，微量有害元素极低，X系数小于15ppm，回火脆化倾向比较小；
 - 适用于焊接低合金铬钼耐热钢，适于化工容器耐热钢的焊接；
 - 适于大型电站锅炉耐热钢的焊接，适于电站设备高温蒸汽管道的焊接。

适用母材 13 CrMo 4-5 (AISI / AWS A 182 - F11 F12) GS-22 CrMo5 - 4

	C	Si	Mn	P	S	Cr	Mo	Cu	Ni	As	Sn	Sb
AWS 化学成分 (Wt. %)	0.05	-	-	-	-	1.00	0.40	-	-	-	-	-
	0.12	0.80	0.90	0.01	0.01	1.50	0.65	-	-	0.005	0.005	0.005
EN	0.05	-	-	-	-	1.00	0.40	-	-	-	-	-
	0.12	0.80	0.90	0.030	0.025	1.50	0.65	-	-	-	-	-
典型值	0.07	0.22	0.75	≤0.010	≤0.010	1.20	0.55	0.10	0.04	≤0.005	≤0.005	≤0.005
X系数≤15ppm												

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)	A ₄ (%)	K _v (J)	
					+20°C	-20°C
AWS	690/1	≥460	≥550	19	-	-
EN	690/1	≥460	≥550	19	≥47	-
	690/1	≥460	≥550	≥22	≥55	≥55
保证值	690/4 ⁺²	310-550	515-620	≥22	55	55
	690/20 ⁺²	310-550	515-620	≥22	55	55

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℃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)
	68948	2.5×300	箱 (3罐)	10.2
	68949	3.2×350	箱 (3罐)	12.6
	68950	4.0×350	箱 (3罐)	12.9
	68951	5.0×450	箱 (3罐)	15.9

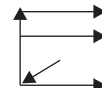
Specification Clas. Code	AWS A5.5	EN ISO 3580-A	GB/T5118
	E8018-B2H4R	E CrMo1 B 42 H5	E5518-1CM

- Properties & Application**
- Basic covered CrMo alloyed electrode.
 - Very good weld ability in out of position work; special designed for hydrogenation reactor and equipment application 1.25Cr-0.5Mo low alloyed steel.
 - Suitable for creep resistant in short time rang up to 500°C (932°F) and in long time rang up to 570°C (1058°F).
 - Low content trace elements, X-factor less than 15ppm, step-cooling tested. Largely insensitive to long-term embrittlement.
 - Suitable for chemical apparatus engineering for the welding of hydrogenation reactor and equipment, heavy-duty boiler, super-heater fabrication, hot steam pipes.

Base Metals 13 CrMo 4-5 (AISI / AWS A 182 - F11 F12) GS-22 CrMo5 - 4.

	C	Si	Mn	P	S	Cr	Mo	Cu	Ni	As	Sn	Sb
AWS Chemical Composition of Undiluted Weld Metal (Wt. %)	0.05	-	-	-	-	1.00	0.40	-	-	-	-	-
	0.12	0.80	0.90	0.01	0.01	1.50	0.65	-	-	0.005	0.005	0.005
EN	0.05	-	-	-	-	1.00	0.40	-	-	-	-	-
	0.12	0.80	0.90	0.030	0.025	1.50	0.65	-	-	-	-	-
Typical	0.07	0.22	0.75	≤0.010	≤0.010	1.20	0.55	0.10	0.04	≤0.005	≤0.005	≤0.005
X-Factor≤15ppm												

Mechanical Properties of All Weld Metal (According to AWS B4.0M)	PWHT (°C/h)	R _{p0.2} (MPa)	R _m (MPa)	A ₄ (%)	K _v (J)	
					+20°C	-20°C
AWS	690/1	≥460	≥550	19	-	-
EN	690/1	≥460	≥550	19	≥47	-
	690/1	≥460	≥550	≥22	≥55	≥55
Guarantee	690/4 ⁺²	310-550	515-620	≥22	55	55
	690/20 ⁺²	310-550	515-620	≥22	55	55

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
	68948	2.5×300	Carton (3 Can)	10.2
	68949	3.2×350	Carton (3 Can)	12.6
	68950	4.0×350	Carton (3 Can)	12.9
	68951	5.0×450	Carton (3 Can)	15.9