

标准	AWS A5.5	EN ISO 3580-A	GB/T5118
标号	E9018-B3H4R	E CrMo2 B 42 H5	E6218-2C1M

特性及应用范围

- 2.25Cr-1Mo低合金钢碱性药皮焊条；
- 其焊缝金属具备良好的抗裂纹性能及在600℃高温下的抗蠕变性能；
- 适用于火电锅炉、管道等设备同类钢材的焊接。

适用母材 10 CrMo 9-10, 12 CrMo 9-10, 10 CrSiMoV 7, 15CrMoV 5-10, SA335Gr. P22, SA217Gr. Wc9, ...

	C	Si	Mn	P	S	Cr	Mo	Ni	Cu	
化学成分 (Wt. %)	AWS	0.05 0.12	- 0.80	- 0.90	- 0.03	- 0.03	2.00 2.50	0.90 1.20	- -	- -
	EN	0.05 0.12	- 0.80	0.40 1.30	- 0.030	- 0.025	2.00 2.60	0.90 1.30	- -	- -
典型值	0.08	0.30	0.78	≤0.015	≤0.015	2.30	1.10	0.04	0.05	

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	-30°C
AWS	690/1	≥530	≥620	≥17	-	-	-
EN	690/1	≥400	≥500	≥18	≥47	-	-
典型值	690/1	640	730	23	180	120	100
保证值	690/1	≥530	≥620	≥20	≥47	≥47	≥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℃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)
	67212	2.5×300	箱 (3罐)	10.2
	67213	3.2×350	箱 (3罐)	12.9
	67214	4.0×350	箱 (3罐)	13.2
	67215	5.0×450	箱 (3罐)	16.5

Specification Clas. Code	AWS A5.5	EN ISO 3580-A	GB/T5118
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Properties & Application

- Basic covered 2.25Cr-1Mo low alloyed steel electrode.
- The weld metal is crack-free and has a good creep resistant in long time range up to 600°C.
- Suitable for welding of matching materials of thermal power applications, such as boiler, pipes, tubes, plate, ...etc.

Base Metals 10 CrMo 9-10, 12 CrMo 9-10, 10 CrSiMoV 7, 15CrMoV 5-10, SA335Gr. P22, SA217Gr. Wc9, ...

	C	Si	Mn	P	S	Cr	Mo	Ni	Cu	
Chemical Composition of Undiluted Weld Metal (Wt. %)	AWS	0.05 0.12	- 0.80	- 0.90	- 0.03	- 0.03	2.00 2.50	0.90 1.20	- -	- -
	EN	0.05 0.12	- 0.80	0.40 1.30	- 0.030	- 0.025	2.00 2.60	0.90 1.30	- -	- -
Typical	0.08	0.30	0.78	≤0.015	≤0.015	2.30	1.10	0.04	0.05	

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	-30°C
AWS	690/1	≥530	≥620	≥17	-	-	-
EN	690/1	≥400	≥500	≥18	≥47	-	-
Typical	690/1	640	730	23	180	120	100
Guarantee	690/1	≥530	≥620	≥20	≥47	≥47	≥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
	67212	2.5×300	Carton (3 Can)	10.2
	67213	3.2×350	Carton (3 Can)	12.9
	67214	4.0×350	Carton (3 Can)	13.2
	67215	5.0×450	Carton (3 Can)	16.5