

Felix 626 (E 8018-B2)

Premium High Strength Basic Coated Electrode For Welding 0.5 Cr 0.5 Mo ,
1 Cr-0.5 Mo , 1.25 Cr 0.5 Mo And Similar Creep Resistant Steels .



Special Features

- * Special Formulation Coating To Resist Moisture Pick Up Under Conditions Of High Heat And Humidity .
- * Weld Metal Is Chromium Molybdenum Alloyed With Operating Temperatures Upto 580° C .
- * Good Arc Stability , Low Spatters And Easily Removable Slag .
- * Low Moisture Reabsorption Quality Prevents Hydrogen Cracking And Eliminates Starting Porosity .

Typical Properties

Tensile Strength	Min 83000 PSI
Yield Strength	Min 74000 PSI
Elongation	Min 24 %
ISO - V (J) + 20° C	Min 100

International Specifications

AWS/ASME A5.5 : E8018 - B2

EN 1599 : E CrMo 1 B 42 H5

Applications

- * For Welding Of 1.25% Cr- 0.5% Mo Heat Resistant Steel Used For Boilers And Associated Tubing .
- * Power Generation, Petrochemical, Pressure Vessels , Process Piping , High Temperature Chemical And Oil Refining Industries .

Recommended Amperage Settings

Diameter (mm)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)	3/16 (5.0)
Length	350	350	350	450
Minimum Amperage	60	90	130	180
Maximum Amperage	85	130	180	230

Welding Techniques

Clean Weld Area . Re-Dry The Electrode At 350° C For 1 Hour . Preheating At 150 - 300° C Is Required Specially For Hardenable Steels To Prevent The Formation Of A Hard Heat-Affected Zone .
Preferred DC Reverse Polarity .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite