



Unibraze 8018-B2 (E8018-B2)

DESCRIPTION:

UNIBRAZE 8018-B2 is an outstanding welding electrode for higher strength steels with tensile strengths greater than 80,000 pounds. The coating is specially formulated to resist moisture pick-up under conditions of high heat and humidity. The electrode offers resistance to moisture reabsorption which helps prevent hydrogen cracking and aids in elimination of starting porosity. Definitely a preferred electrode with high operator appeal.

APPLICATIONS:

UNIBRAZE 8018-B2 is used for fabrication and maintenance of boilers and associated piping. Such steels as 1 1/4 Cr-1/2 Mo, and 1/2 Cr-1/2 Mo, are properly welded with UNIBRAZE 8018-B2.

FEATURES:

- Good arc characteristics
- Low spatter level
- Quick and easy slag removal
- Low moisture reabsorption
- Low smoke level
- Low hydrogen less than 4 ml/100 g

BENEFITS:

- Stable, easy to control arc
- Improves weld bead appearance, higher deposition
- Reduces clean-up time
- Prevents starting porosity
- Welder safety and comfort
- Resistant to hydrogen-induced cracking

TYPICAL WELD METAL PROPERTIES Chem Pad):

Weld Metal Analysis

Carbon (C)	0.07	AWS Spec	0.12 max
Manganese (Mn)	0.71		0.90 max
Sulphur (S)	0.009		0.03 max
Phosphorus (P)	0.010		0.03 max
Silicon (Si)	0.62		0.80 max
Chromium (Cr)	1.30		1.00 to 1.50
Molybdenum (Mo)	0.55		0.40 to 0.65

TYPICAL MECHANICAL PROPERTIES*:

Stress relieved 1 hour at 1275°F AWS Spec

Tensile Strength	102,000 psi (705 MPa)	80,000 min
Yield Strength	91,000 psi (625 MPa)	67,000 min
Elongation % in 2"	21%	19% min

TYPICAL CHARPY V-NOTCH IMPACT VALUES*(AW):

AWS Spec

Avg. at -20°F (-20°C)	42 ft•lbs	—
Avg. at -40°F (-40°C)	35 ft•lbs	—

DIFFUSIBLE HYDROGEN: 2.3 ml/100 gr

CONFORMANCES AND APPROVALS:

- AWS A5.5, E8018-B2 H4R, ASME SFA 5.5, E8018-B2
- ABS

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its product.



- GENERAL:** Electrode positive, work negative (DCEP) or AC
ARC LENGTH: Very short arc
FLAT: Angle electrode 10-15° from 90°
VERTICAL-UP: Use weaving techniques
VERTICAL-DOWN: Not recommended
OVERHEAD: Use slight weaving motion within the puddle
STORAGE: After opening, store in holding oven (220°F to 350°F) until used.
RECONDITIONING: If exposed to atmosphere for extended periods, reconditioned for one (1) hour at 600°F.

RECOMMENDED OPERATING PARAMETERS:

Diameter		Type of Power	Minimum Amps	Optimum* Amps	Maximum Amps
Inches	mm				
3/32	2.4	DCEP or AC	70	100	110
1/8	3.2	DCEP or AC	90	135	160
5/32	4.0	DCEP or AC	130	170	220
3/16	4.8	DCEP or AC	200	250	300

*For out of position welding, reduce amperages shown by 15%.

TYPICAL DEPOSITION RATES (at Optimum):

Diameter		Type of Power	Amperage	Deposition Rate Lbs/Hr.
Inches	mm			
3/32	2.4	DCEP	100	2.47
1/8	3.2	DCEP	145	2.87
5/32	4.0	DCEP	190	3.84
3/16	4.8	DCEP	275	5.86

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