

# Inweld 9018-B3L

AWS A5.5 E9018-B3L

## Chemical Composition of Inweld 9018-B3L

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
Balance	0.05	2.00- 2.50	---	0.90- 1.20	0.90	0.80	0.03	0.03	---	---

Single values are maximum unless otherwise specified.

## Description and Applications

For welding 2-1/4 Chrome - 1% Molybdenum power piping tubes, boilers and castings subjected to elevated temperatures exceeding 850°F (450°C). All-position, iron powder, low hydrogen electrode with a low carbon analysis for greater crack resistance and lower preheat temperatures than 9018-B3. Commonly used for super heater tubes and steam pipes of boilers in electric power generation plants, equipment for oil refinery industries, and high temperature synthetic chemical industries. Excellent mechanical properties in the “as-welded” or stress relieved conditions. Typical applications include piping steels (A335-P22), rolled steels (A387 Gr.22), cast steels (A217-WC), forged steels (A182-F22, 336-F22), boiler and heat exchanger steel tubes (A199-T22, A200-T22, A213-T22) Preheat at 325 - 375°F and post-heat at 1275°F +/- 25°F.

## Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	100,000 psi
Yield Strength:	84,000 psi
Elongation:	17%

## Recommended Parameters

SMAW (DCEP – Electrode+)

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
3/32”		70-110
1/8”		90-160
5/32”		130-220

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