Atom Arc 9018-CM

The principal application of Atom Arc 9018-CM electrodes is for welding 2 1/2% Cr - 1% Mo steels commonly found in pressure vessels, heat exchangers, pipings and other related components.

Classifications	AWS A5.5 : E9018-B3H4R
Approvals	A.B.S.- AWS A5.5 E9018-B3 MILITARY-MIL-E-0022200/8 MIL-9018-B3
Industry	Pipeline Power Generation

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	AC or DC+
Coating Type	Low-hydrogen iron powder

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
Stress Relieved 8hr 685°C (1275°F)	0 °C (32 °F)	131 J (97 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Cr	Mo	X-bar
0.07	0.70	0.40	0.008	0.011	2.20	1.10	<15

Deposition Data

Diameter	Optimal Amps	Current	Deposition Rate	Deposition Efficiency %
2.4 mm (3/32 in.)	90 A	70-100 A	0.8 kg/h (1.7 lb/h)	66.3 %
3.2 mm (1/8 in.)	120 A	90-160 A	1.2 kg/h (2.6 lb/h)	71.6 %
3.2 mm (1/8 in.)	140 A	90-160 A	1.2 kg/h (2.7 lb/h)	70.9 %
4.0 mm (5/32 in.)	140 A	130-220 A	1.1 kg/h (3.1 lb/h)	75 %
4.0 mm (5/32 in.)	170 A	130-220 A	1.7 kg/h (3.8 lb/h)	73.5 %
4.8 mm (3/16 in.)	200 A	200-300 A	2.2 kg/h (4.9 lb/h)	76.4 %
4.8 mm (3/16 in.)	250 A	200-300 A	2.4 kg/h (5.4 lb/h)	74.6 %

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