



KISWEL

KISWEL – K-9018B3R

Classifications:

AWS A5.5: E9018-B3 H4R

EN ISO 3580-A: S CrMo2 B 4 2 H5

Typical Chemistry Composition of Weld Deposit:

C	Si	Mn	Cr	S	Mo
0.05 – 0.12	<0.80	<0.90	2.00 – 2.50	<0.030	0.90 – 1.20

Description:

- For welding in power plants, heat exchangers and oil refinery applications for 2.25%Cr-1.0%Mo heat-resistant steel.
- Diffusible Hydrogen Content <4ml/100g

Typical Mechanical Properties:

Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)	Impact Value (J)
min. 530	min. 620	min. 17	35 (0°C)

Packaging:

SMAW Electrode (Ø in mm): 2.60 MM / 3.20 MM / 4.00 MM / 5.00 MM in 20.00 Kg Case

Welding Parameters:

Wire Diameter	Shielding Gas	Current (A)	
		Min.	Max.
2.60 mm	-	60	100
3.20 mm		90	130
4.00 mm		140	190
5.00 mm		190	250



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