

1NiMo.B

TOP FEATURES

- All-positional stick electrode for welding of WB36/P36 steels
- Moisture resistant coating provides very low weld metal hydrogen levels
- Recovery is about 120%

TYPICAL APPLICATIONS

- Feedwater piping systems
- Headers, manifolds and fittings in power stations

CLASSIFICATION

AWS A5.5
EN ISO 18275-A

E9018-G
E 55 4 1NiMo B 3 2 H5

CURRENT TYPE

DC+/AC

WELDING POSITIONS

All position, except vertical down

APPROVALS

TÜV

+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	V
Min.	0.05	1.0	not specified	not specified	not specified	not specified	0.8	0.20	not specified	not specified
Max.	0.12	1.4	0.5	0.020	0.025	0.3	1.2	0.50	0.10	0.03
Typical	0.07	1.2	0.3	0.01	0.01	0.1	1.0	0.4	0.05	0.01

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Properties after PWHT		Min.	20 °C	Typical (590-620 °C /1-2h)		450 °C
				250 °C	350 °C	
Tensile strength	(MPa)	620	744	650	640	545
0.2% Proof strength	(MPa)	550	677	505	445	432
Elongation (%)	4d	17	25	22	28	24
	5d	not specified	22	-	-	-
Reduction of area (%)		not specified	65	57	69	73
Impact ISO-V (J)	0 °C	not specified	130	-	-	-

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 350	80-140
4.0 x 450	100-180

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 350	CBOX	120	4.5	1NiMOB-32-2
4.0 x 450	CBOX	80	5.6	1NiMOB-40-2

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.