

ROCKWELD B2



ROCKWELD B2 is a basic type electrodes for creep resisting steels and cast steels with 1% Cr and 0.5% Mo operating at temperatures up to 550°C. Good weldability in all positions. Low spatter loss. Smooth bead appearance. Good slag removal.

CLASSIFICATIONS

AWS	A5.5	E8018-B2
BS	2493	I Cr Mo BH
DIN	8575	E Cr Mo I B 20+

CHEMICAL ANALYSIS

% Carbon	0.060	% Molybdenum	0.500
% Manganese	0.800	% Sulphur	<0.02
% Silicon	0.400	% Phosphorous	<0.02
% Chromium	1.000		

**TYPICAL MECHANICAL PROPERTIES
(ALL WELD METAL IN THE AS
WELDED CONDITION)**

Tensile Strength	560 - 660 MPa
Yield Strength	>480 MPa
% Elongation on 5d	>18%
Impact Strength ISO-V at 20°C	>50j

PACKING DATA

Diameter (mm)	Amps	Item Number	Pack Mass (Kg)
2.50	60-90	078-254	3x5
3.20	90-130	078-256	3x5
4.00	140-180	078-258	3x5

The information contained or otherwise referenced herein is presented only as typical without guarantee or warranty, and Afrox expressly disclaims any liability incurred from any reliance thereon. No data is to be construed as recommended for any welding condition or technique not controlled by Afrox.

For more information contact the Afrox Customer Service Centre,
tel: 0860 020202 or e-mail: customer.service@afrox.boc.com
Website: www.afrox.com

