

**ROYAL- 8015 B8 (E 8015 B8)**

AWS : SFA 5.5, E 8015 B8

**Applications**

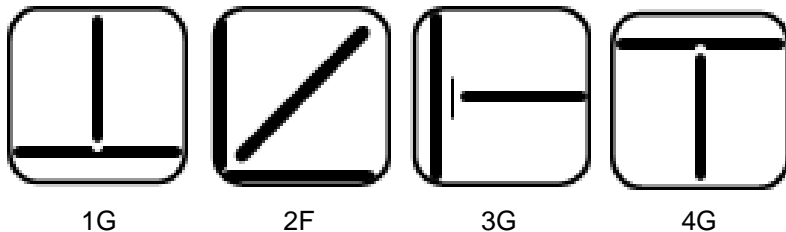
It is used for welding of 9% Cr, plates, pipe, tubes. It is also used for welding of 7 to 10% Cr, 1% Mo steel for general corrosion and heat resistance application. Surfacing of turbine Blades, Valve, Seats

**Characteristics on Usage**

A basic coated medium alloy low hydrogen electrode specially developed for welding of Ferritic, Martensitic chrome steels. It gives weld deposit which has contain 9% Cr, 1% Mo having excellent creep strength upto 625°C and resistance to oxidizing atmosphere upto 700°C. Proper preheating and post heating is required for weld made with these electrodes. The weld deposit gives radiographic quality of welds. Dry the electrodes at 300°C before welding to obtain best results.

**Notes On Usage**

- ✍ 1) Preheat at 200 - 350 °C and postheat at  $740 \pm 15$  °C.
- ✍ 2) Dry the electrode at 350-400 °C for 60 Min- before use.

**Welding Positions****Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo
0.05 -0.10	1.00 Max	0.90 Max	0.030 Max	0.030 Max	8.0 – 10.50	0.40 Max	0.85 –

**Mechanical Properties Of Weld Metal**

(After PWHT at  $740 \pm 15$ °C for 1 Hr soaking)

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
550 Min	460 Min	19 % Min

**Packing and Welding Current**

SIZE ( mm )	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 X 350	2	18	DC (+)	60 – 90
3.15 X 350	2	18		100 – 140
4.00 X 350	2	18		140 – 180
5.00 X 350	2	18		180 – 230

**Packing**

Vaccum packing