



Quality Management System
in accordance with
ISO 9001:2000
Cert # 05-R0925

8015-B8, 8016-B8 8018-B8

Low-Alloy Steel Electrode

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



ALLOY DESCRIPTION AND APPLICATION;

USA 801X-B8 (formerly 505 family) is a high Cr-Mo covered electrode commonly used in the oil and chemical industries and where base metal such as 9% Cr, 1% Mo steels are found. Typical base metals found in this group are ASTM grades: A182-F9, A336-F9, A199-T9, A200-T9, A213-T9, A335-P9, A369-FP9, A426-CP9, A217-C12, and A387-Gr9. Idea for high pressure hydrogen service.

TYPICAL WELDING PROCEDURES; OPTIMUM IN BOLD

Diameter	3/32"	1/8"	5/32"	3/16"	1/4"
Length	14"	14"	14"	14"	18"
Amps Flat	70- 90 -100	90- 140 -160	130- 170 -220	190- 235 -290	265- 325 -400
Vertical up & Overhead	60- 85 -90	80- 110 -120	110- 145 -170		

Arc Length = Very short arc, Flat use 15° angle from 90°, Vertical up & Overhead use weaving techniques within puddle
8015-B8 = Low-hydrogen sodium coating /DCEP
8016-B8 = Low-hydrogen potassium coating /DCEP or ac
8018-B8 = Low-hydrogen potassium, iron powder coating /DCEP or ac

Procedures may vary with change in position, base metals, filler metals, equipment and other changes. Preheat and postheat recommended

TYPICAL WELD METAL CHEMISTRY (%) AND WELD METAL PROPERTIES;

	AWS Spec.		AWS Spec.
Carbon	0.05-0.10	Tensile Strength (psi)	80,000 min.
Manganese	1.00 max	Yield Strength (psi)	67,000
Silicon	0.90 max	Elongation in 2"	19 % min.
Phosphorus	0.030 max.		
Sulfur	0.030 max.		
Nickel	0.40 max		
Chromium	8.00-10.50		
Molybdenum	0.85-1.20		

AVAILABLE SIZES: TE 801X-B6 = 10 # containers of 3/32, 1/8,
Other sizes may be available – please inquire

SPECIFICATIONS; ANSI/AWS A5.5 E8015-B8 , E8016-B8 , 8018-B8
ASME SFA A5.5 E8015-B8 , E8016-B8 , 8018-B8
(Formerly AWS A 5.4, Class E505-15 , E505-16 , N/A FOR -18)

EAST COAST	GULF COAST	WEST COAST
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8-2007 DC

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