

# ESL'ARC 98B3

## Classification

AWS -  
A 5.5 E9018-B3

## Applications

For welding high tensile and low alloy steel containing approximately 2.25% Cr, 1% Mo in boiler, power plant, oil refineries, chemical plants etc.

## Characteristics

ESL'ARC 98B3 is a heavy coated low hydrogen iron powder type electrode producing a weld deposit containing 2.25% Cr, 1% Mo which is oxidation resistance up to 575°C. It gives high purity radiographic quality weld deposits, It is suitable for welding 2.25% Cr, 1% Mo steel as well as cast iron of similar composition.

## Welding Current (AMPS) AC / DC

6.30X450mm	5.00X450mm	4.00X450mm	3.15X450mm	2.50X350mm
250-330	200-250	150-200	100 -140	70 -100

## Typical chemical composition of all weld metal:

C%	Cr%	Mo%	Mn.%	Si%	S%	P%
0.07	2.25	1.00	0.65	0.35	0.024	0.022

## Typical Mechanical Properties of Weld Metal:

UTS	YS	Impact	Elongation L = 5D
650 N/mm2 min	560 N/mm2	60 J at -40° C	26%



## Shieldarc Equipment Pvt. Ltd.

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