



# WB10018-D2 M.M.A. WELDING ELECTRODE

**Classifications** AWS A5.5-06 : E10018-D2-H4 R BS EN ISO 18275:2012 : E62 5 MnMo B T 3 2 H5

**Approvals** ABS 3YQ550

**Product Description** All positional, basic coated, low hydrogen, high strength electrode depositing exceptionally clean metal of high radiographic quality. The addition of iron powder gives a recovery of ~ 110%.

**Applications** Used for the welding of medium to high tensile strength steels. Widely used for welding pressure vessels, forgings and castings with excellent sub-zero toughness after tempering/post weld heat treatment. Typical grades ASTM A487 2B, AISI 4130, 4140, BS970 709M40 (En19).

All-Weld Metal Composition (Weight %)		C	Mn	Si	S	P	Mo	Cr	Ni	V
min.		0.05	1.65	0.15	-	-	0.30	0.10	0.70	-
max.		0.10	2.00	0.40	0.020	0.025	0.45	0.20	0.90	0.030

<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength	N/mm <sup>2</sup>	713
	Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	643
	Elongation on 5D	%	25
	Impact Energy CV @ -51°C	Joules	91
	Stress-relieved @ 620°C/1 Hr		

Electrode Dia (mm)	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
Electrode Length (mm)	-	-	350	450	450	450	450
Current Range (Amps)	min.	-	70	110	135	160	220
	max.	-	100	145	180	220	300

**Packaging Information**

Kg Per Vac-Pac	-	-	2	2	2	2	2
Approx. Pieces Per Kg	-	-	44	21	15	10	7
Vac Pac Kg Carton	-	-	20	20	20	20	20

**Storage**

It is recommended that the WB range of electrodes are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%. To avoid damage to the coatings no more than 6 cartons should be staked on top of another.

**Storage and Re-Drying**

**Re-drying if standard packaging**

Re-dry @ 350°C for 2 hours and then transfer to holding oven and hold @ 100 - 200°C, or 50-100°C in heated quiver.

**Current Conditions AC (OCV70) DC+ and Welding Positions**

