



WB12018-M M.M.A. WELDING ELECTRODE

Classification AWS A5.5-06 : E12018-M BS EN ISO 18275:2012 : E794Mn2Ni1CrMoB42H5

Product Description Fully positional, basic coated, low hydrogen electrode. Exceptional mechanical properties. Has a nominal recovery of ~110%. Excellent de-slag, re-strike and general welder appeal.

Application Used for the welding of HY80, HY100 and other high yield alloy steels where the weld metal properties must match those of the parent material after normalising followed by quenching and tempering.

All-Weld Metal Composition (Weight %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	V
min.		0.03	1.30	0.20	-	-	0.40	2.00	0.30	-	-
max.		0.06	2.00	0.40	0.020	0.025	0.80	2.50	0.55	0.050	0.050

Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength	N/mm ²	830 min.
	Yield Stress/0.2% Proof Stress	N/mm ²	745-830
	Elongation on 5D	%	18
	Impact Energy CV @ -51°C	Joules	27
	As-welded		

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	90	130	160	230
	max.	-	-	90	130	180	220	280

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 and Re-baking **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%.

Re-drying 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

