



WB2318E M.M.A. WELDING ELECTRODE

Classifications AWS A5.5 : E9018-M

Approvals ABS : 4YQ460

Product Description All positional, basic coated, low hydrogen electrode depositing exceptionally clean metal of radiographic quality. Excellent de-slag with good welder appeal. The addition of iron powder gives a recovery of ~ 110%.

Applications Widely used for the welding of low alloy steel of a tensile strength 600/700 N/mm² such as RQT600, HY80, NAXTRA 70. Frequently used for tack welding steels of higher tensile strength.

All-Weld Metal Composition (Weight %)		C	Mn	Si	S	P	Mo	Cr	Ni	V
min.		0.03	0.80	0.20	-	-	0.20	-	1.60	-
max.		0.05	1.25	0.50	0.020	0.025	0.35	0.05	1.80	0.05

Typical All-Weld Metal Mechanical Properties		N/mm ²	
Ultimate Tensile Strength		660	
Yield Stress/0.2% Proof Stress		580	
Elongation on 5D	%	24	
Impact Energy CV @ -51°C As-welded	Joules	65	

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

Storage

Storage and Re-Drying 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 stacked on top of another.

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

