



WB2518E M.M.A. WELDING ELECTRODE

Classification AWS A5.5-04 : E11018-M

Product Description All positional, basic coated, low hydrogen electrode depositing exceptionally clean metal of radiographic quality with excellent de-slag and welder appeal. The addition of iron powder gives a recovery of ~ 110%. Excellent impact values at sub-zero temperatures.

Applications Widely used for the welding of steels with a tensile strength of 750/850 N/mm², such as RQT600, RQT701, HY80, HY100, NAXTRA 70 and T1.

All-Weld Metal Composition (Weight %)

	C	Mn	Si	S	P	Mo	Cr	Ni	V
min.	0.04	1.35	0.20	-	-	0.25	-	2.00	-
max.	0.07	1.80	0.50	0.020	0.025	0.50	0.20	2.50	0.030

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm ²	*779 **748
Yield Stress/0.2% Proof Stress	N/mm ²	*700 **669
Elongation on 5D	%	*23 **25
Impact Energy CV @ -51°C	Joules	*78 **104 (-20oC)
*As-welded		
**PWHT @ 610°C/8hours		

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.	-	60	105	140	160	220
	max.	-	90	140	180	210	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

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 staked 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

