



WB504-18 M.M.A. WELDING ELECTRODE

Classifications

AWS A5.5-2006 : E8018-B8

BSEN1599-97 : ECrMo9 B 4 2 H5

Product Description

Fully positional, highly basic coated, low hydrogen electrode for welding creep-resisting steels.

Excellent de-slag, re-strike and general welder appeal. The addition of iron powder gives a recovery of ~ 110%.

Applications

Suitable for welding 9%Cr 1%Mo creep-resisting steels. Used mainly by the power engineering industry for headers, steam piping and turbine rotors.

Typical material grades :- ASTM A336 Grade F9, ASTM A217 C12, BS1504 Grade 629 and BS3100 Grades 629/470. DIN G-X 12CrMo 10 1, ASTM A335 Grades P9.

All-Weld Metal Composition (Weight %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	V
min.	0.05	0.60	0.20	-	-	8.0	0.20	0.90	-	-
max.	0.10	1.00	0.80	0.020	0.020	10.0	0.40	1.20	0.10	0.030

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm ²	675
Yield Stress/0.2% Proof Stress	N/mm ²	549
Elongation on 5D	%	21
Impact Energy CV @ +20°C	Joules	70
Stress-relieved @ 760°C/2 Hrs		

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 Packet	-	-	2	2	2	2	2
Approx. Pieces Per Kg	-	-	44	21	14	10	7

Storage and Re-Drying**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 stacked on top of another.

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