



# WB7018-1 VP M.M.A. WELDING ELECTRODE

**Classifications** ASME II C/AWS A5.1-04 : E7018-1H4 BS EN ISO 2560A E424B 32H4

**Approvals** ABS 4Y : LRS 3YH

**Product Description** All positional, basic, low hydrogen electrode depositing weld metal of faultless radiography quality. The iron powder addition realises a recovery of ~ 120% and excellent impact properties are achieved down to -46°C. Excellent weld finish and a high degree of welder appeal, de-slag, re-strike etc.

**Applications** Recommend for the welding of mild/medium tensile steels up to grade 50D, having a tensile strength of 500 N/mm<sup>2</sup>, A and D ship steel, BS1449 plate and sheet. Its high deposition rate is most apparent when used as a fill after rooting with WB2116E/WB56S

**All-Weld Metal Composition (Weight %)**

	C	Mn	Si	S	P	Mo	Cr	Ni	V	Cu
<b>min.</b>	0.03	1.00	0.20	-	-	-	-	-	-	-
<b>max.</b>	0.08	1.50	0.50	0.030	0.030	0.08	0.08	0.10	0.02	0.08

<b>Typical All-Weld Metal Mechanical Properties</b>			<u>As-Welded</u> <u>PWHT (600°C/1 hr)</u>	
Ultimate Tensile Strength	N/mm <sup>2</sup>		550	520
Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>		510	460
Elongation on 5D	%		30	34
Impact Energy CV @ -20°C	Joules		140	150
Impact Energy CV @ -30°C	Joules		90	110
Impact Energy CV @ -46°C	Joules		55	60

<b>Electrode Dia (mm)</b>	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm
<b>Electrode Length (mm)</b>	-	-	350	450	450	450
<b>Current Range (Amps)</b>	<b>min.</b>	-	70	90	130	160
	<b>max.</b>	-	90	130	180	220

**Packaging Information**

<b>Kg Per Vac Pac</b>	-	-	2	2	2	2
<b>Approx. Pieces Per Kg</b>	-	-	44	21	15	10
<b>Kg per Carton</b>	-	-	20	20	20	20

**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 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**

