



# WB8018-B2 M.M.A. WELDING ELECTRODE

## Classifications

AWS A5.5-96 : E8018-B2

BSEN1599-97:ECrMo1 B 3 2 H5

## Product Description

Fully positional, basic coated, low hydrogen electrode for welding low alloy creep-resisting steels. The addition of iron powder gives a recovery of ~ 120%. Excellent de-slag, re-strike and welder appeal.

Suitable for welding 1.25%Cr 0.5%Mo creep-resisting steels.

## Applications

Typical grades:- BS1501:Part 2 620, BS1503 Grade 620/621, BS1504 Grade 620 and BS3100 Grade B2, ASTM A335 Grades P11 & P12, A182 F11, ASTM A199, A200 & A213.

Scaling and creep resistance to 550°C.

## All-Weld Metal Composition (Weight %)

	C	Mn	Si	S	P	Mo	Cr	V	Cu
min.	0.08	0.70	0.20	-	-	0.45	1.00	-	-
max.	0.12	0.90	0.80	0.020	0.025	0.65	1.30	0.03	0.03

## Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm <sup>2</sup>	645
Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	556
Elongation on 5D	%	24
Impact Energy CV @ +20°C	Joules	85
Stress relieved @ 690°C / 1Hr		

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	110	135	160	220
	max.	-	-	100	145	180	220	300

## Packaging Information

Kg Per Packet	-	-	5	5	5	5	5
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. Opened Vac packs must be used within an 8 hour shift.

### 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

