



WB8018-C3 M.M.A. WELDING ELECTRODE

Classifications AWS A5.5-2006 : E8018-C3 BSEN499-95:E46 4 1Ni B 32 H5

Product Description Fully positional, basic coated, low hydrogen electrode. The product exhibits self lifting slag and excellent re-strike.
Exceptional mechanical and radiography properties.

Applications Used for the welding of higher strength C-Mn, low alloy and weathering steels. Materials are often supplied in the normalised and tempered condition, combining high strength with good toughness at low temperatures.
Used extensively for offshore oilfield sour service applications where a maximum 1%Ni is required.

All-Weld Metal Composition (Weight %)		C	Mn	Si	S	P	Mo	Cr	Ni	V	Cu
min.		0.05	0.90	0.15	-	-	0.20	-	0.80	-	-
max.		0.12	1.25	0.50	0.020	0.025	0.35	0.05	1.00	0.02	0.03

Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength	N/mm ²	622
	Yield Stress/0.2% Proof Stress	N/mm ²	549
	Elongation on 5D	%	27
	Impact Energy CV @ -55°C	Joules	120

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 staked 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

