



WB8018-C1 M.M.A. WELDING ELECTRODE

Classifications	AWS A5.5-96 : E8018-C1		BSEN499-95 : E50 6 2Ni B 3 2 H5								
Product Description	Fully positional, basic coated, low hydrogen electrode depositing 2%Ni weld metal, exceptionally clean metal of radiographic quality with excellent de-slag and welder appeal. The addition of iron powder gives a recovery of ~ 120%.										
Applications	Used on a variety of fabrications to match stringent classification requirements. Used extensively for low temperature fabrications where good notch toughness (-60°C) is required coupled with C.T.O.D. values. Typical material grades:- BS1501-224-Grade 490B, ASTM A302 Grades A&B, ASTM a333 Grade 6 pipe, ASTM A350 Grades LF1/LF2. In addition WB8018-C1 has been used for welding and repairing weathering steels.										
All-Weld Metal Composition (Weight %)		C	Mn	Si	S	P	Mo	Cr	Ni	V	Cu
min.		0.03	0.50	0.10	-	-	-	-	2.0	-	-
max.		0.12	1.25	0.50	0.020	0.025	0.03	0.05	2.6	0.05	0.02
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		568						
	Yield Stress/0.2% Proof Stress		N/mm ²		482						
	Elongation on 5D		%		30						
	Impact Energy CV @ -59°C		Joules		121						
	Stress-relieved @ 620°C/1 Hr										

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	15	10	7
Vac Pac Approx. Kg Carton	-	-	6.4	10.8	11.1	11.1	12.0
Storage and Re-Drying	<p>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.</p> <p>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.</p>						

Current Conditions AC (OCV70) DC+/- and Welding Positions

