



WB7018-G M.M.A. WELDING ELECTRODE

Classifications & Approvals	AWS A5.5-96 : E7018-G BSEN499-95 : E50 6 Mn1Ni B 3 2 H5 LRS:C-MnLT60										
Product Description	Fully positional, basic coated, low hydrogen electrode depositing exceptionally clean metal of radiographic quality with excellent de-slag and re-strike. The addition of iron powder gives a recovery of ~ 120%.										
Applications	It is suitable for offshore constructions in steel such as BS4360-50D. Good impact values down to -60°C. Can be used for the welding of weathering steels, such as Cor-Ten A and Cor-Ten B. Excellent weldability on both AC and DC.										
All-Weld Metal Composition (Weight %)		C	Mn	Si	S	P	Mo	Cr	Ni	V	Cu
min.		0.04	1.40	0.10	-	-	-	-	0.6	-	-
max.		0.10	2.00	0.40	0.020	0.025	0.05	0.05	1.0	0.01	0.05
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		651						
	Yield Stress/0.2% Proof Stress		N/mm ²		562						
	Elongation on 5D		%		28						
	Impact Energy CV @ -60°C as-welded		Joules		52						

Electrode Dia (mm)	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm	
Electrode Length (mm)	-	-	350	350 / 450	450	450	450	
Current Range (Amps)	min.	-	-	60	90	130	170	230
	max.	-	-	90	135	180	230	280
Packaging Information								
Kg Per Packet	-	-	5	5	5	5	5	
Approx. Pieces Per Kg	-	-	44	21	15	10	7	
Vac Pac Approx. Kg Carton	-	-	6.0	7.2/10.4	12.0	11.4	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

