WB2218E MMA WELDING ELECTRODE

Classifications	**AWS A5.5:** E8018-G H4R **RCC-M**
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 (3.20-6.00) gives a recovery of ~ 110%.
Applications	It is suitable for offshore constructions in steel such as 550/600 N/mm2 such as RQT 500, API 5L X60, X65 & X70. Excellent weldability on both AC and DC±.

All-Weld Metal Composition (Wt. %)	C	Mn	Si	S	P	Mo	Cr	Ni	V	Cu
min.	0.05	1.40	0.20	-	-	0.25	-	0.6	-	-
max.	0.10	1.80	0.50	0.025	0.025	0.65	0.05	1.0	0.01	0.08

Typical All-Weld Metal Mechanical Properties		
Ultimate Tensile Strength	N/mm²	645 **625
Yield Stress/0.2% Proof Stress	N/mm²	550 **502
Elongation on 5D	%	24 **24
Impact Energy CV @ -20°C	Joules	60 **49
As welded		
**PWHT @ 615°C/15 HRS		

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
Current Range (Amps)	**min.**	-	-	50	80	130	170	230
	max.	-	-	80	135	180	230	280
Packaging Information								
Kg Per Packet		-	-	2	2	2	2	2
Approx. Pieces Per Kg		-	-	44	21	15	10	7
Vac Pac Approx. Kg Carton		-	-	20	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