



WB7018-1 MMA WELDING ELECTRODE

Classifications / Approvals	AWS A5.1: E7018-1H4R EN ISO 2560A: E46 5 B 3 2 H5 ABS: 3YH									
Product Description	All positional, basic, low hydrogen electrode depositing weld metal of faultless radiography quality. The iron powder addition realises a recovery of ~ 120% and excellent impact properties are achieved down to -46°C. Excellent weld finish and a high degree of welder appeal, de-slag, re-strike etc.									
Applications	Recommend for the welding of mild/medium tensile steels up to grade 50D, having a tensile strength of 500 N/mm ² , Lloyds A and D ship steel, BS1449 plate and sheet. Its high deposition rate is most apparent when used as a fill after rooting with WB56S.									
All-Weld Metal Composition (Weight %)										
min.	C	Mn	Si	S	P	Mo	Cr	Ni	V	Cu
max.	0.03	1.00	0.20	-	-	-	-	-	-	-
	0.08	1.60	0.50	0.030	0.030	0.18	0.06	0.10	0.02	0.05

Typical All-Weld Metal Mechanical Properties		Min.	Min. PWHT (600°C/1hr)	
		As welded		
	Ultimate Tensile Strength	N/mm ²	570	520
	Yield Stress/0.2% Proof Stress	N/mm ²	480	460
	Elongation on 5D	%	26	30
	Impact Energy CVN @ -20°C	Joules	140	150
	Impact Energy CVN @ -30°C	Joules	130	140
	Impact Energy CVN @ -46°C	Joules	110	120
Impact Energy CVN @ -51°C	Joules	75	90	

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	100	130	160	230
	max.	-	115	140	180	220	280
Packaging Information							
Kg Per Packet	-	-	2	2	2	2	2
Approx. Pieces Per Kg	-	-	44	21	15	10	7
Vac Pac Kg per 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 cartons should be stacked no more than 4 high.
	Re-drying if standard packaging
	Re-dry @ 350°C for 2 hours and then transfer to holding oven and hold @ 100°C-200°C, or 50°C-100°C in heated quiver.

Current Conditions AC OCV70 DC +/- and Welding Positions

