



WB8018-B2 MMA WELDING ELECTRODE

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|---|--|------|--|------|-------|-------|------|------|------|------|
| Classifications | AWS A5.5: E8018-B2 | | BS EN ISO 3580-A: ECrMo1 B 3 2 H5 | | | | | | | |
| Product Description | Fully positional, basic coated, low hydrogen electrode for welding low alloy creep-resisting steels. The addition of iron powder gives a recovery of ~ 120%. Excellent de-slag, re-strike and welder appeal. | | | | | | | | | |
| Applications | Suitable for welding 1.25%Cr 0.5%Mo creep-resisting steels. Typical grades:- BS1501:Part 2 620, BS1503 Grade 620/621, BS1504 Grade 620 and BS3100 Grade B2, ASTM A335 Grades P11 & P12, A182 F11, ASTM A199, A200 & A213. Scaling and creep resistance to 550°C. | | | | | | | | | |
| All-Weld Metal Composition (Wt. %) | | C | Mn | Si | S | P | Mo | Cr | V | Cu |
| min. | | 0.08 | 0.70 | 0.20 | - | - | 0.45 | 1.00 | - | - |
| max. | | 0.12 | 0.90 | 0.80 | 0.020 | 0.025 | 0.65 | 1.30 | 0.03 | 0.03 |
| Typical All-Weld Metal Mechanical Properties | Ultimate Tensile Strength | | N/mm ² | | >550 | | | | | |
| | Yield Stress/0.2% Proof Stress | | N/mm ² | | >460 | | | | | |
| | Elongation on 5D | | % | | >19 | | | | | |
| | Impact Energy CV @ +20°C | | Joules | | 85 | | | | | |
| | Stress relieved @ 690°C / 1Hr | | | | | | | | | |

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|------------------------------|---|-------|-------|-------|-------|-------|-------|
| 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 | - | - | 20 | 20 | 20 | 20 | 20 |
| Approx. Pieces Per Kg | - | - | 44 | 21 | 14 | 10 | 7 |
| 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 4 cartons should be stacked on top of another. Opened Vac packs must be used within an 8 hour shift.</p> <p>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.</p> | | | | | | |

Current Conditions AC OCV70 DC +/- and Welding Positions

