



WB8018-B2 MMA WELDING ELECTRODE

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								

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 6 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>
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Current Conditions AC OCV70 DC +/- and Welding Positions

