WB8018-C1 M.M.A. WELDING ELECTRODE

Classifications	AWS A5.5: E8018-C1 EN ISO 2560A: E46 6 2Ni B 3 2 H5
Product Description	Fully positional, basic coated, low hydrogen electrode depositing 2%Ni weld metal, exceptionally clean metal of radiographic quality with excellent de-slag and welder appeal. The addition of iron powder gives a recovery of ~120%.
Applications	Used on a variety of fabrications to match stringent classification requirements. Used extensively for low temperature fabrications where good notch toughness (-60°C) is required coupled with C.T.O.D. values. Typical material grades: - BS1501-224-Grade 490B, ASTM A302 Grades A&B, ASTM A333 Grade 6 pipe, ASTM A350 Grades LF1/LF2. In addition, WB8018-C1 has been used for welding and repairing weathering steels.

All-Weld Metal Composition (Weight %)	C	Mn	Si	S	P	Mo	Cr	Ni	V	Cu
min.	0.03	0.50	0.10	-	-	-	-	2.0	-	-
max.	0.12	1.25	0.50	0.025	0.030	0.03	0.05	2.6	0.05	0.10

Typical All-Weld Metal Mechanical Properties		
Ultimate Tensile Strength	N/mm²	560
Yield Stress/0.2% Proof Stress	N/mm²	480
Elongation on 5D	%	25
Impact Energy CV @ -60°C	Joules	75
Stress-relieved @ 620°C/1 Hr		

Electrode Dia (mm)		1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	
Electrode Length (mm)		-	-	350	450	450	450	
Current Range (Amps)	**min.**	-	-	70	110	135	160	
	max.	-	-	100	145	180	220	
Packaging Information								
Kg Per Packet		-	-	5	5	5	5	
Approx. Pieces Per Kg		-	-	44	21	15	10	
Vac Pac Approx. Kg Carton		-	-	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 4 cartons should be stacked 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°C-200°C, or 50°C-100°C in heated quiver.

Current Conditions AC (OCV70) DC+/- and Welding Positions