



WB7018-1 MMA WELDING ELECTRODE

Classifications	AWS A5.1: E7018-1 H4 R BS EN ISO 2560-A: E 46 5 B 3 2 H5										
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 -51°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 (Wt. %)		C	Mn	Si	S	P	Mo	Cr	Ni	V	Cu
min.		0.03	1.00	0.20	-	-	-	-	-	-	-
max.		0.08	1.55	0.50	0.030	0.030	0.20	0.06	0.06	0.02	0.05

Typical All-Weld Metal	Ultimate Tensile Strength	N/mm ²	PWHT	
			<u>As welded</u>	<u>(600°C/1 hr)</u>
Mechanical Properties			588	565
	Yield Stress/0.2% Proof Stress	N/mm ²	501	490
	Elongation on 5D	%	26	30
	Impact Energy CV @ -20°C	Joules	150 Avg.	160
	Impact Energy CV @ -30°C	Joules	130 Avg.	140
	Impact Energy CV @ -40°C	Joules	110 Avg.	125
	Impact Energy CV @ -51°C	Joules	75 Avg.	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	230	280
Packaging Information							
Kg Per Packet	-	-	2.0	2.0	2.0	2.0	2.0
Approx. Pieces Per Kg	-	-	47	21	14	9	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.



Approvals: LR, ABS (3Y)