



# WB7018-1 MMA WELDING ELECTRODE

<b>Classifications / Approvals</b>	AWS A5.1: E7018-1H4R EN ISO 2560A: E46 5 B 3 2 H5 ABS: 3YH									
<b>Product Description</b>	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.									
<b>Applications</b>	Recommend for the welding of mild/medium tensile steels up to grade 50D, having a tensile strength of 500 N/mm <sup>2</sup> , 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.									
<b>All-Weld Metal Composition (Weight %)</b>										
<b>min.</b>	C	Mn	Si	S	P	Mo	Cr	Ni	V	Cu
<b>max.</b>	0.03	1.00	0.20	-	-	-	-	-	-	-
	0.08	1.50	0.50	0.030	0.030	0.18	0.06	0.10	0.02	0.05

<b>Typical All-Weld Metal Mechanical Properties</b>		Min.	Min. PWHT	
		As welded	(600°C/1hr)	
	Ultimate Tensile Strength	N/mm <sup>2</sup>	570	520
	Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	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	

<b>Electrode Dia (mm)</b>	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
<b>Electrode Length (mm)</b>	-	-	350	450	450	450	450
<b>Current Range (Amps)</b>	<b>min.</b>	-	70	100	130	160	230
	<b>max.</b>	-	115	140	180	220	280
<b>Packaging Information</b>							
<b>Kg Per Packet</b>	-	-	2	2	2	2	2
<b>Approx. Pieces Per Kg</b>	-	-	44	21	15	10	7
<b>Vac Pac Kg per Carton</b>	-	-	20	20	20	20	20

<b>Storage and Re-Drying</b>	<b>Storage</b> 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.
	<b>Re-drying if standard packaging</b> 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

