



# WB8018-C1 MMA WELDING ELECTRODE

<b>Classifications</b>	<b>AWS A5.5: E8018-C1-H4</b>										
<b>Product Description</b>	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%.										
<b>Applications</b>	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 CTOD 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.										
<b>All-Weld Metal Composition (Weight %)</b>		C	Mn	Si	S	P	Mo	Cr	Ni	V	Cu
<b>min.</b>		0.03	0.50	0.10	-	-	-	-	2.0	-	-
<b>max.</b>		0.12	1.25	0.50	0.020	0.025	0.03	0.05	2.6	0.05	0.02
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength		N/mm <sup>2</sup>		598						
	Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>		532						
	Elongation on 5D		%		30						
	Impact Energy CV @ -60°C		Joules		121						
	Stress-relieved @ 620°C/1 Hr										

<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	110	130	160	220
	<b>max.</b>	-	-	100	150	180	220	300
<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 Approx. Kg Carton</b>	-	-	20.0	20.0	20.0	20.0	20.0	
<b>Storage and Re-Drying</b>	<p><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 6 cartons should be staked on top of another.</p> <p><b>Re-drying if standard packaging</b> 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

