



WB7018-A1 MMA WELDING ELECTRODE

Classifications	AWS A5.5: E7018-A1 BS EN ISO 2560-A: E 42 2 Mo B 3 2 H5										
Product Description	All positional, basic coated, low hydrogen electrode (>4ml/g) depositing exceptionally clean metal of radiographic quality. The addition of iron powder gives a recovery of ~ 110% and excellent re-strike properties.										
Applications	Used for the welding of medium to high tensile strength steels. Widely used for welding pressure vessels, forgings, and castings with excellent sub-zero toughness after tempering/post weld heat treatment. Typical material grades: - BS1504 Gr 245, BS3100 Gr B1, ASTM A217 WC1, A352 LC1, DIN GS-22Mo 4, ASTM A336 F1 A204 ABC, BS3059 Gr 243, BS3606 Grs 243, 245, 261.										
All-Weld Metal Composition (Weight %)		C	Mn	Si	S	P	Mo	Cr	Ni	V	Nb
	min.	0.04	0.60	0.15	-	-	0.30	-	-	-	-
	max.	0.06	1.40	0.30	0.020	0.025	0.60	0.06	0.06	0.03	0.01
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		558						
	Yield Stress/0.2% Proof Stress		N/mm ²		459						
	Elongation on 5D		%		29						
	Impact Energy CV @ -20°C stress relieved @620°C/1Hr		Joules		105						

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.	-	60	105	140	160	220
	max.	-	90	140	180	210	280
Packaging Information							
Kg Per Packet	-	-	2	2	2	2	2
Approx. Pieces Per Kg	-	-	44	21	15	10	7
Vac Pac Approx. Kg Carton	-	-	20.0	20.0	20.0	20.0	20.0
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 4 cartons should be staked on top of another.</p> <p>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.</p>						

Current Conditions AC OCV70 DC +/- and Welding Positions

