



# WB10018-D2 MMA WELDING ELECTRODE

<b>Classifications</b>	<b>AWS A5.5:</b> E10018-D2-H4 R <b>BS EN ISO 18275:</b> E62 5 MnMo B T 3 2 H5								
<b>Product Description</b>	All positional, basic coated, low hydrogen, high strength electrode depositing exceptionally clean metal of high radiographic quality. The addition of iron powder gives a recovery of ~ 110%.								
<b>Applications</b>	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 grades ASTM A487 2B, AISI 4130, 4140, BS970 709M40 (En19).								
<b>All-Weld Metal Composition (Weight %)</b>	C	Mn	Si	S	P	Mo	Cr	Ni	V
<b>min.</b>	0.05	1.65	0.15	-	-	0.25	-	0.60	-
<b>max.</b>	0.15	2.00	0.80	0.025	0.025	0.45	0.20	1.00	0.030
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength	N/mm <sup>2</sup>	*713						
	Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	*643						
	Elongation on 5D	%	*25						
	Impact Energy CV @ -51°C	Joules	*91						
	Stress-relieved @ 650°C/6 Hrs		*actuals						

<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>	-	60	90	130	160	220
	<b>max.</b>	-	100	140	180	220	300
<b>Packaging Information</b>							
<b>Kg Per Packet</b>	-	-	5	5	5	5	5
<b>Approx. Pieces Per Kg</b>	-	-	44	21	15	10	7
<b>Vac Pac Approx. Kg Carton</b>	-	-	6.4	10.8	11.4	11.1	11.4
<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 stacked 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

