



# WB9018-G MMA WELDING ELECTRODE

<b>Classifications</b>	<b>AWS A5.5:</b> E9018-G <b>BS EN ISO 18275-A:</b> E 55 6 1NiMo B 4 2 H5										
<b>Product Description</b>	Fully positional, basic coated, low hydrogen, self lifting slag electrode.										
<b>Applications</b>	<p>Used for the welding and repair high strength, high yield materials such as ASTM A508 Class 1, 1a, 3, ASTM A533 types A-D Class 1 &amp; 2, BS1501 grades 271 &amp; 281, Ducol 30 grades A&amp;B.</p> <p>Primarily designed for welding and fabricating high integrity pressure parts where good PWHT mechanical values are required.</p>										
<b>All-Weld Metal Composition (Wt. %)</b>		C	Mn	Si	S	P	Mo	Cr	Ni	V	Cu
<b>min.</b>		0.03	1.40	0.20	-	-	0.20	-	0.7	-	-
<b>max.</b>		0.07	1.60	0.50	0.020	0.025	0.40	0.05	1.0	0.03	0.05
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength		N/mm <sup>2</sup>		680						
	Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>		540						
	Elongation on 5D		%		24						
	Impact Energy CV @ -60°C		Joules		85						
	Stress-relieved @ 620°C/1Hr										

<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	90	130	160	230
	<b>max.</b>	-	-	90	130	180	220	280
<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>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 4 cartons should be staked on top of another.</p> <p><b>Re-drying</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

