



## WB2318E M.M.A. WELDING ELECTRODE

<b>Classifications</b>	AWS A5.5: E9018-M										
<b>Product Description</b>	All positional, basic coated, low hydrogen electrode depositing exceptionally clean metal of radiographic quality. Excellent de-slag with good welder appeal. The addition of iron powder gives a recovery of ~ 110%.										
<b>Applications</b>	Widely used for the welding of low alloy steel of a tensile strength 600/700 N/mm <sup>2</sup> such as RQT600, HY80, NAXTRA 70. Frequently used for tack welding steels of higher tensile strength.										
<b>All-Weld Metal Composition (Weight %)</b>		C	Mn	Si	S	P	Mo	Cr	Ni	V	
<b>min.</b>		0.03	0.80	0.20	-	-	0.20	-	1.60	-	
<b>max.</b>		0.05	1.25	0.50	0.020	0.025	0.35	0.05	1.80	0.05	
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength		N/mm <sup>2</sup>		660						
	Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>		580						
	Elongation on 5D		%		24						
	Impact Energy CV @ -51°C		Joules		89						
	As welded										

<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	120	160	230
	<b>max.</b>	-	-	90	130	200	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>Vac Pac Approx. Kg Carton</b>		-	-	6.4	10.8	10.8	10.8	10.8
<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

