WB8018-W2 MMA WELDING ELECTRODE

Classifications	AWS A5.5: E8018-W2
Product Description	All positional basic coated low alloy, low hydrogen electrode. Excellent welder appeal, mechanical & radiography properties.
Applications	Used for the welding of weathering steels, Cor-ten steel and equivalents, ASTM A242 & ASTM A588.

All-Weld Metal Composition (Weight %)	**C**	**Mn**	**Si**	**S**	**P**	**Cr**	**Ni**	**Cu**	
min.	-	0.50	0.35	-	-	0.45	0.40	0.30	
max.	0.12	1.30	0.80	0.020	0.025	0.70	0.80	0.75	
Typical	0.06	1.1	0.5	0.007	0.018	0.6	0.6	0.45	

Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength	670MPa
	Yield Stress/0.2% Proof Stress	600MPa
	Elongation on 5D	30%
	Impact Energy CV @ -20°C	100J
	As-welded	

Electrode Dia (mm)		1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
Electrode Length (mm)		-	-	350	350	350	450	-
Current Range (Amps)	**min.**	-	-	80	110	135	160	-
	max.	-	-	110	140	180	220	-
Packaging Information								
Kg Per Vac Pack		-	-	2	2	2	2	-
Approx. Pieces Per Kg		-	-	43	22	14	10	-

Storage and Re-baking

Storage
It is recommended that the WB range of electrodes is 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.

Re-drying
If required, 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.

POLARITY AND WELDING POSITIONS AC OCV70 DC +/-