



# WB2318E M.M.A. WELDING ELECTRODE

<b>Classifications</b>	AWS A5.5: E9018-M      EN ISO 18275-A: E 55 5 Z1.5NiMo B 3 2									
<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	Nb
<b>min.</b>	0.03	0.60	0.20	-	-	0.20	-	1.40	-	-
<b>max.</b>	0.10	1.25	0.60	0.020	0.025	0.35	0.10	1.80	0.05	0.05
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength		N/mm <sup>2</sup>		620-780					
	Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>		550 Min					
	Elongation on 5D		%		24 Min					
	Impact Energy CV @ -51°C		Joules		75					
	As-welded									

<b>Electrode Dia (mm)</b>	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	
<b>Electrode Length (mm)</b>	-	-	350	450	450	450	
<b>Current Range (Amps)</b>	<b>min.</b>	-	70	90	130	160	
	<b>max.</b>	-	90	130	180	220	
<b>Packaging Information</b>							
<b>Kg Per Packet</b>	-	-	2	2	2	2	
<b>Approx. Pieces Per Kg</b>	-	-	44	21	15	10	
<b>Vac Pac Approx. Kg Carton</b>	-	-	20	20	20	20	
<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 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°C-200°C, or 50°C-100°C in heated quiver.</p>						

## Current Conditions AC OCV70 DC +/- and Welding Positions

