



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	<p>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 4 cartons should be stacked on top of another.</p> <p>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.</p>						

POLARITY AND WELDING POSITIONS AC OCV70 DC +/-

