



# WB7018-A1 MMA WELDING ELECTRODE

<b>Classifications</b>	<b>AWS A5.5:</b> E7018-A1 <b>BS EN ISO 2560-A:</b> E 42 2 Mo B 3 2 H5										
<b>Product Description</b>	All positional, basic coated, low hydrogen electrode (>4ml/g) depositing exceptionally clean metal of radiographic quality. The addition of iron powder gives a recovery of ~ 110% and excellent re-strike properties.										
<b>Applications</b>	Used for the welding of medium to high tensile strength steels. Widely used for welding pressure vessels, forgings, and castings with excellent sub-zero toughness after tempering/post weld heat treatment.  Typical material grades: - BS1504 Gr 245, BS3100 Gr B1, ASTM A217 WC1, A352 LC1, DIN GS-22Mo 4, ASTM A336 F1 A204 ABC, BS3059 Gr 243, BS3606 Grs 243, 245, 261.										
<b>All-Weld Metal Composition (Weight %)</b>		C	Mn	Si	S	P	Mo	Cr	Ni	V	Nb
<b>min.</b>		0.04	0.60	0.15	-	-	0.30	-	-	-	-
<b>max.</b>		0.06	1.40	0.30	0.020	0.025	0.60	0.06	0.06	0.03	0.01
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength		N/mm <sup>2</sup>		558						
	Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>		459						
	Elongation on 5D		%		29						
	Impact Energy CV @ -20°C stress relieved @620°C/1Hr		Joules		105						

<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>	-	60	105	140	160	220
	<b>max.</b>	-	90	140	180	210	280
<b>Packaging Information</b>							
<b>Kg Per Packet</b>	-	-	2	2	2	2	2
<b>Approx. Pieces Per Kg</b>	-	-	44	21	15	10	7
<b>Vac Pac Approx. Kg Carton</b>	-	-	20.0	20.0	20.0	20.0	20.0
<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 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 - 200°C, or 50-100°C in heated quiver.</p>						

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

