



WB8018-C2 M.M.A. WELDING ELECTRODE

Classifications

AWS A5.5-04 : E8018-C2

Product Description

Fully positional, basic coated, low hydrogen electrode depositing 3%Ni weld metal, exceptionally clean metal of radiographic quality with excellent de-slag and welder appeal. The addition of iron powder gives a recovery of ~ 120%.

Applications

Used widely for the welding and fabrication of 3% Ni steels and fine grained steels. WB8018-C2 is used extensively in the petro-chem industry for welding cryogenic pipework.

Typical material grades :- BS1501-503, BS1503-503, ASTM A350-Grade LF3. Suitable for operating temperatures down to -101°C.

All-Weld Metal Composition (Weight %)

	C	Mn	Si	S	P	Mo	Cr	Ni	V	Cu
min.	0.03	0.50	0.10	-	-	-	-	3.00	-	-
max.	0.12	1.25	0.50	0.020	0.025	0.03	0.05	3.75	0.05	0.02

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm ²	621
Yield Stress/0.2% Proof Stress	N/mm ²	557
Elongation on 5D	%	24
Impact Energy CV @ -73°C	Joules	40
Impact Energy CV @ -101°C	Joules	35
Stress-relieved @ 605°C/1 Hr		

Electrode Dia (mm)	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
Electrode Length (mm)	-	-	350	450	450	450	450
Current Range (Amps)	min.	-	70	110	135	160	220
	max.	-	100	145	180	220	300

Packaging Information

Kg Per Packet	-	-	5	5	5	5	5
Approx. Pieces Per Kg	-	-	44	21	14	10	7

Storage and Re-Drying

Storage

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.

Re-drying

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.

Current Conditions AC (OCV70) DC+/- and Welding Positions

