



WB10018-D2 M.M.A. WELDING ELECTRODE

Classifications	AWS A5.5: E10018-D2-H4 R									
Product Description	All positional, basic coated, low hydrogen, high strength electrode depositing exceptionally clean metal of high radiographic quality. The addition of iron powder gives a recovery of ~110%.									
Applications	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 grades ASTM A487 2B, AISI 4130, 4140, BS970 709M40 (EN19).									
All-Weld Metal Composition (Weight %)		C	Mn	Si	S	P	Mo	Cr	Ni	V
min.		0.06	1.65	0.20	-	-	0.25	-	0.60	-
max.		0.15	2.00	0.80	0.025	0.030	0.45	0.20	0.90	0.05
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		725 min					
	Yield Stress/0.2% Proof Stress		N/mm ²		586 min					
	Elongation on 5D		%		18 min					
	Impact Energy CV @ -46°C		Joules		46 min					
	Stress-relieved @ 650°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		-	-	20	20	20	20	20
Approx. Pieces Per Kg		-	-	44	21	15	10	7
Vac Pac Approx. Kg Carton		-	-	2	2	2	2	2
Storage and Re-Drying	<p>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 4 cartons should be stacked on top of another.</p> <p>Re-drying if standard packaging 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

