



WB2518E MMA WELDING ELECTRODE

Classification	AWS A5.5: E11018-M H4 MIL-11018-M MIL-E-222000/1									
Product Description	All positional, basic coated, low hydrogen electrode depositing exceptionally clean metal of radiographic quality with excellent de-slag and welder appeal. The addition of iron powder gives a recovery of ~ 110%. Excellent impact values at sub-zero temperatures.									
Applications	Widely used for the welding of steels with a tensile strength of 750/850 N/mm ² , such as RQT600, RQT701, HY80, HY100, NAXTRA 70 and T1.									
All-Weld Metal Composition (Wt. %)	C	Mn	Si	S	P	Mo	Cr	Ni	V	
min.	0.04	1.35	0.20	-	-	0.25	-	2.00	-	
max.	0.07	1.80	0.50	0.020	0.025	0.50	0.20	2.50	0.030	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		*779 **748					
	Yield Stress/0.2% Proof Stress		N/mm ²		*700 **669					
	Elongation on 5D		%		*23 **25					
	Impact Energy CV @ -51°C		Joules		*78 **104 (-20oC)					
	*As welded									
	**PWHT @ 610°C/8hours									

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.	-	60	90	130	160	220
	max.	-	90	140	180	220	280
Packaging Information							
Kg Per Packet	-	-	5	5	5	5	5
Approx. Pieces Per Kg	-	-	44	21	15	10	7
Vac Pac Approx. Kg Carton	-	-	6.4	10.8	11.4	11.4	12.0
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 6 cartons should be staked 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 - 200°C, or 50-100°C in heated quiver.</p>						

Current Conditions AC (OCV70) DC+ and Welding Positions

