



WB1500E M.M.A. WELDING ELECTRODE

Classification

AWS A5.15-90: ENi-CI

BSEN1071-2003 : E C Ni-CI 3

Product Description

Low strength weld for cast iron. Deposits almost pure Nickel that is fully machinable. Narrow fusion zone, thus minimal HAZ. Smooth, quiet welding arc.

Application

Can weld all standard grades of grey and malleable cast irons, typically cylinder heads and blocks and pump castings. The stable arc achieved on low currents reduces penetration and dilution, producing machinable crack-free welds.

All-Weld Metal Composition (Weight %)

	C	Mn	Ni	Si	S	P	Al	Cu+Ag
min.	1.0	0.10	88	0.30	-	-	-	-
max.	2.0	0.40	-	1.00	0.02	0.02	0.10	0.10

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm ²	-
Yield Stress/0.2% Proof Stress	N/mm ²	-
Elongation on 5D	%	-
Impact Energy CV @	Joules	-

Electrode Dia (mm)	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
Electrode Length (mm)	-	-	350	350	350	350	-
Current Range (Amps)	min.	-	55	75	95	145	-
	max.	-	85	115	155	185	-

Packing Information

Kg Per Packet	-	-	5	5	5	5	-
Approx. Pieces Per Kg	-	-	50	32	21	13	-

Storage and Re-baking

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

If damp re-dry @ 180°C for 1 hour.

Current Conditions AC (OCV70) DC+ and Welding Positions

