



WB1600E M.M.A. WELDING ELECTRODE

Classification

AWS A5.15-90: ENiFe-CI

BSEN1071-2003 : E C NiFe-C1 3

Product Description

High strength weld for cast iron. Deposits a Nickel-Iron alloy.

Deposit is fully machinable. Narrow fusion zone, thus minimal HAZ. Smooth, quiet welding arc.

Application

Used mainly for welding nodular graphite or spheroid graphite (SG) cast irons. WB1600E is also suitable for welding the austenitic Ni-Resist irons and alloy cast irons.

All-Weld Metal Composition (Weight %)

	C	Mn	Ni	Si	S	P	Al	Cu+Ag	Fe
min.	1.0	0.50	45.0	0.50	-	-	-	-	Bal.
max.	2.0	2.50	60.0	4.00	0.02	0.02	0.10	0.10	

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm ²	495
Yield Stress/0.2% Proof Stress	N/mm ²	380
Elongation on 5D	%	10
Impact Energy CV @	Joules	-
Hardness	Hv10	170

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 stacked on top of another.

Re-drying

If damp re-dry @ 180°C for 1 hour.

Current Conditions AC (OCV70) DC+ and Welding Positions

