



WB1700E M.M.A. WELDING ELECTRODE

Classification	AWS A5.15 ENiCu-B BSEN1071:2003 : E C NiCu-B 3							
Product Description	Medium strength weld for Nickel-Copper based cast irons. Smooth quiet arc.							
Applications	Deposits a Nickel-Copper deposit on all grades of cast iron and gives a machinable deposit with excellent colour match for decorative work. WB1700E is used extensively for repairing industrial ovens, gates etc.							
All-Weld Metal Composition (Weight %)	C	Mn	Ni	Si	S	P	Cu+Ag	Fe
min.	0.35	0.80	60	-	-	-	25	3.0
max.	0.55	2.30	70	0.75	0.025	0.025	35	6.0
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		-			
	Yield Stress/0.2% Proof Stress		N/mm ²		-			
	Elongation on 5D		%		-			
	Charpy Vee Impact @		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	-
Packaging Information							
Kg Per Packet	-	-	5	5	5	5	-
Approx. Pieces Per Kg	-	-	50	32	21	13	-
Storage and Re-baking	<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 damp re-dry @ 180°C for 1 hour.</p>						

Current Conditions AC OCV70 DC +/- and Welding Positions

