



WB2000E M.M.A. WELDING ELECTRODE

Classifications / Approvals AWS A5.1-04 : E6013 BSEN 499-95 : E42 A R 1 2 LRS :GRADE 1

Product Description Easy to use all purpose contact electrode, recommended where a neat weld appearance and high finish is required. Excellent de-slag with little or no spatter.

Applications Mild and medium C-Mn steels up to 15mm thick with a UTS of 500 N/mm² max. Typical grades - BS1449 plate and steel - BS4360 grades 43A, 43C - Lloyds grade A and D ship steel - BS4360 grade 50B - Lloyds grade AH and DH - BS3059 and BS3601 grade 320-420 - AP15L and AP15L 42.

| All-Weld Metal Composition (Weight %) | | C | Mn | Si | S | P | Ni | Cr | Mo | V | Cu |
|--|--|------|------|------|-------|-------|------|------|------|-------|-------|
| min. | | 0.05 | 0.40 | 0.20 | - | - | - | - | - | - | - |
| max. | | 0.11 | 0.70 | 0.70 | 0.020 | 0.025 | 0.05 | 0.05 | 0.03 | 0.050 | 0.050 |

| | | | |
|---|--------------------------------|-------------------|-----|
| Typical All-Weld Metal Mechanical Properties | Ultimate Tensile Strength | N/mm ² | 610 |
| | Yield Stress/0.2% Proof Stress | N/mm ² | 520 |
| | Elongation on 5D | % | 22 |
| | Impact Energy CV @ +20°C | Joules | 60 |

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|------------------------------|-------------|-------|-------|-------|-------|-------|-------|-------|
| Electrode Dia (mm) | | 1.6mm | 2.0mm | 2.5mm | 3.2mm | 4.0mm | 5.0mm | 6.0mm |
| Electrode Length (mm) | | 300 | 300 | 350 | 450 | 450 | 450 | 450 |
| Current Range (Amps) | min. | 30 | 40 | 70 | 90 | 130 | 160 | 190 |
| | max. | 50 | 60 | 100 | 135 | 165 | 200 | 250 |

Packaging Information

| | | | | | | | |
|------------------------------|-----|----|----|----|----|----|---|
| Kg Per Packet | 5 | 5 | 5 | 5 | 5 | 5 | 5 |
| Approx. Pieces Per Kg | 134 | 92 | 55 | 25 | 16 | 11 | 7 |

Storage and Re-Drying **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 these electrodes become excessively damp re-dry @ 100°C for 1 hour.

Current Conditions AC OCV70 DC +/- and Welding Positions

