WB2024E M.M.A. WELDING ELECTRODE

Classifications & Approvals	AWS A5.1-91 : E6013 BSEN499-95 : E422R12 LRS : GRADE 3Y
Product Description	Rutile coated electrode with a self lifting slag. Excellent strike and re-strike with virtually no tendency to stick. It is particularly suitable for vertical and overhead welding and has been developed primarily for users who prefer one electrode for all positions.
Applications	Excellent all-positional general purpose electrode for welding mild steel wrought iron and may be used on many grades of cast and medium tensile steel. Typical uses include the welding of storage tanks, pressure vessels, car bodies, ship building and for pipe fittings and pipe butt welds using the vertical-up technique.

All-Weld Metal Composition (Weight %)

	C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
min.	0.04	0.30	0.10	-	-	-	-	-	-	-
max.	0.08	0.70	0.30	0.025	0.020	0.05	0.05	0.03	0.050	0.050

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm²	507
Yield Stress/0.2% Proof Stress	N/mm²	420
Elongation on 5D	%	26
Impact Energy CV @ -20°C As-welded	Joules	76

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.**	-	-	50	100	120	180	220
	max.	-	-	90	145	180	240	285

Packaging Information

Kg Per Packet	-	-	5	5	5	5	5
Approx. Pieces Per Kg	-	-	53	26	17	11	7

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 these electrodes become excessively damp re-dry @ 100°C for 1 hour.

Current Conditions OCV70 DC +/- and Welding Positions