



# WB2044E M.M.A. WELDING ELECTRODE

<b>Classifications</b>	AWS A5.1-91 : E6013      BSEN 499-95 : E42 A RC 1 5									
<b>Product Description</b>	Rutile coated rutile electrode particularly suited for welding in the vertical-down position due to its quick freezing slag. Constant current settings for all positions.									
<b>Applications</b>	Excellent fully 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 pipefittings and pipe butt-welds in all positions. Excellent for poorly fitting work.									
<b>All-Weld Metal Composition (Weight %)</b>	C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
<b>min.</b>	0.03	0.20	0.20	-	-	-	-	-	-	-
<b>max.</b>	0.07	0.50	0.70	0.020	0.025	0.03	0.03	0.02	0.02	0.05
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength		N/mm <sup>2</sup>		511					
	Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>		433					
	Elongation on 5D		%		25					
	Charpy Vee Impact @ +20°C As-welded		Joules		60					

<b>Electrode Dia (mm)</b>	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
<b>Electrode Length (mm)</b>	-	-	350	350	350	-	-
<b>Current Range (Amps)</b>	<b>min.</b>	-	50	100	120	-	-
	<b>max.</b>	-	90	145	180	-	-
<b>Packaging Information</b>							
<b>Kg Per Packet</b>	-	-	5	5	5	-	-
<b>Approx. Pieces Per Kg</b>	-	-	53	26	17	-	-
<b>Storage and Re-baking</b>	<p><b>Storage</b> 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><b>Re-drying</b> If these electrodes become excessively damp re-dry @ 100°C for 1 hour.</p>						

## Current Conditions AC OCV70 DC +/- and Welding Positions

