



WB2092E M.M.A. WELDING ELECTRODE

Classifications	AWS A5.1-91 : E7024 BSEN 499-95 : E42 3RR 7 4									
Product Description	High deposition rutile electrode with a self detaching slag and a nominal recovery of ~ 180%									
Applications	Mild and medium C-Mn steels up to 15mm thick with a UTS of 500 N/mm ² max. BS4360 grades 42A-50B - BS3601 320-410 and AP15L A-B, X42.									
All-Weld Metal Composition (Weight %)	C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
min.	0.08	0.50	0.40	-	-	-	-	-	-	-
max.	0.12	1.25	0.90	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		547			
	Yield Stress/0.2% Proof Stress				N/mm ²		446			
	Elongation on 5D				%		29			
	Impact Energy CV @ -30°C				Joules		39			
	As-welded									

Electrode Dia (mm)	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
Electrode Length (mm)	-	-	350	450	450	450	-
Current Range (Amps)	min.	-	90	140	175	220	-
	max.	-	120	175	220	280	-
Packaging Information							
Kg Per Packet	-	-	5	5	5	5	-
Approx. Pieces Per Kg	-	-	40	18	12	7	-
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 these electrodes become excessively damp re-dry @ 100°C for 1 hour.</p>						

Current Conditions AC OCV70 DC +/- and Welding Positions

