



# WB4202E M.M.A. WELDING ELECTRODE

<b>Classifications</b>	AWS A5.4-2006 E410NiMo-26	BSEN1600-97:E13 4 R 5 3
<b>Product Description</b>	Heavy coated, mild steel core wire, rutile electrode with a substantial metal powder addition to the coating. Having exceptional deslag and arc stability, this electrode produces a recovery of ~ 180%.	
<b>Applications</b>	Suitable for the welding of high strength Martensitic stainless steels having better resistance to corrosion, hydro-cavitation, sulphide-induced S.C.C. and good sub-zero toughness compared with standard 12%Cr steels. Developed primarily for CA-6NM castings. Additional material grades :- BS3100 425C11, ASTM F6NM-CA6NM, DIN 14351 1.4313 G-X5CrNi 13 4 & AFNOR Z6 CND 1304-M. Components :- Valve bodies, compressor cones, impellers and high pressure pipe in power generation. Moisture resistant content give low weld metal hydrogen content will be in the 5-10ml/100g range.	

All-Weld Metal Composition (Weight %)	C	Mn	Si	S	P	Mo	Cr	Ni	Cu
	min.	0.04	0.30	0.10	-	-	0.4	11.0	4.0
max.	0.06	1.00	0.60	0.020	0.025	0.7	12.5	5.0	0.050

<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength	N/mm <sup>2</sup>	927
	Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	792
	Elongation on 5D	%	19
	Impact Energy CV @ +20°C	Joules	38
	stress relieved @ 605°C / 1Hr		

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.	-	70	90	120	160	-
	max.	-	110	140	180	220	-



### Packaging Information

<b>Kg Per Packet</b>	-	-	2	2	2	2	-
<b>Approx. Pieces Per Kg</b>	-	-	36	17	11	7	-

**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**  
Re-dry @ 350°C for 2 hours and then transfer to holding oven and hold @ 100 - 200°C, or 50-100°C in heated quiver.

### Current Conditions AC (OCV70) /DC + and Welding Positions

					
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