



WB4405E M.M.A. WELDING ELECTRODE

| | | | | | | | | | | |
|---|---|------|------|-------|-------|-------------------|------|------|------|--|
| Classifications | ~AWS A5.4-92 : E308Mo-15 | | | | | | | | | |
| Product Description | All positional, basic coated, 308Mo stainless steel electrode having excellent deslag and bead profile. | | | | | | | | | |
| Applications | Used for welding hardenable high strength steels, such as armour plate with typically 0.3C, 2Cr, 0.5Ni, 0.4Mo. Materials:- ARMOUR PLATE - MVEE 816 (MoD), Armax 816 (Swedish Steel) Compass B555 (Sleeman). 13%Mn (Hadfield's) steel Red diamond 14 (spartan redheugh), Abro M (Creusot). <0.4%C hardenable steels such as: BS970 709M40(En19), 817M40(En24), 826M40(En26), 897M39 (En40C). WEAR-RESISTANT STEELS such as:- Hardox 400 and 500 (Swedish Steel), ARQ360, A-R-COL (British Steel), Creusabro 4000, Abro 360 and 500 (Crusot), ABR 500 (Taysteel), Red Diamond 20, 21, 22 (spartan redburgh) Typical 20FN. | | | | | | | | | |
| All-Weld Metal Composition (Weight %) | C | Mn | Si | S | P | Mo | Cr | Ni | Cu | |
| | min. 0.04 | 1.30 | 0.40 | - | - | 2.80 | 19.0 | 9.5 | - | |
| | max. 0.07 | 2.50 | 0.80 | 0.020 | 0.025 | 3.50 | 21.0 | 12.0 | 0.20 | |
| Typical All-Weld Metal Mechanical Properties | Ultimate Tensile Strength | | | | | N/mm ² | 810 | | | |
| | Yield Stress/0.2% Proof Stress | | | | | N/mm ² | 560 | | | |
| | Elongation on 5D | | | | | % | 22 | | | |
| | Impact Energy CV @ +20°C as-welded | | | | | Joules | 80 | | | |

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|------------------------------|--|-------|-------|-------|-------|-------|-------|
| 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. | - | 60 | 80 | 100 | 130 | - |
| | max. | - | 90 | 120 | 150 | 210 | - |
| Packaging Information | | | | | | | |
| Kg Per Packet | - | - | 5 | 5 | 5 | 5 | - |
| Approx. Pieces Per Kg | - | - | 50 | 30 | 19 | 12 | - |
| 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 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.</p> | | | | | | |

POLARITY AND WELDING POSITIONS AC OCV70 DC +/-

