



# WB4480E M.M.A. WELDING ELECTRODE

**Classifications** AWS A5.4-06 : E307-26

**Product Description** Semi-positional, rutile coated mild steel core wire electrode having excellent deslag and bead profile. Recovery is approximately 160%

**Applications** Used mainly for welding, repairing and surfacing Austenitic manganese steels. Deposits ~4% Manganese which is crack resistant. Can also be used for surfacing, buttering and joining mild steels, hardenable and stainless steels to each other. Weld deposit can be fully heat treated without loss of properties.

All-Weld Metal Composition (Weight %)	C	Mn	Si	S	P	Mo	Cr	Ni	Cu
	<b>min.</b>	0.08	3.30	0.30	-	-	0.5	18.0	9.0
<b>max.</b>	0.12	4.75	0.60	0.020	0.025	1.5	21.0	10.7	0.20

<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength	N/mm <sup>2</sup>	620
	Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	388
	Elongation on 5D	%	47
	Impact Energy CV @ +20°C as-welded	Joules	65
	Hardness	Hv	~200 AW, ~380 Work hardened

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)	<b>min.</b>	-	60	80	100	130	-
	<b>max.</b>	-	90	120	150	210	-

### Packaging Information

Kg Per Vac Pac	-	-	2	2	2	2	-
Approx. Pieces Per Kg	-	-	28	15	10	7	-
Vac Pac Approx. Kg Carton	-	-	20	20	20	20	-

<b>Storage and Re-baking</b>	<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.
	<b>Re-drying</b> 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

