



WB4505E M.M.A. WELDING ELECTRODE

Classifications

AWS A5.4-06 : E316L-17

BS EN 1600 E 19 12 3 L

Product Description

All positional, rutile coated, Austenitic stainless steel electrode depositing Molybdenum bearing weld metal. Excellent deslag and outstanding welding properties.

Applications

Used mainly for welding and repairing 316L stainless steels and wrought and cast alloys 316, S62, CF3M, CF8M and 316C12 it is also suitable for the mixed welding of 304L, 316L, 321 and 347 stainless steels. Ferrite in the 3-10FN range. Corrosion resistant up to 400°C.

All-Weld Metal Composition (Weight %)

	C	Mn	Si	S	P	Mo	Cr	Ni	Cu
min.	0.01	0.50	0.60	-	-	2.5	18.0	11.0	-
max.	0.03	1.20	0.90	0.020	0.025	3.0	20.0	13.0	0.20

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm ²	588
Yield Stress/0.2% Proof Stress	N/mm ²	459
Elongation on 5D	%	39
Impact Energy CV @ +20°C as-welded	Joules	68

Electrode Dia (mm)	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm	
Electrode Length (mm)	-	350	350	350	350	350	-	
Current Range (Amps)	min.	-	40	60	80	100	130	-
	max.	-	75	80	110	150	210	-

Packaging Information

Kg Per Vac Pac	-	2	2	2	2	2	-
Approx. Pieces Per Kg	-	71	50	30	19	12	-

Storage and Re-baking

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 stacked 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

