



WB4555E M.M.A. WELDING ELECTRODE

Classifications

AWS A5.4-06 : E309L-16

BS EN ISO 3581-A - E23 12 L R 1 2

All positional, rutile coated, 309L stainless steel electrode. Excellent deslag and outstanding welding properties.

Applications

Used mainly for welding stainless steels and wrought and cast alloys to carbon steels such as 304 clad steels. This is known as a transition weld used largely for pressure vessel fabrications. For cladding it deposits a 308 type deposit on carbon steel and can be followed by 307-weld metal. 8-20FN range.

All-Weld Metal Composition (Weight %)

	C	Mn	Si	S	P	Mo	Cr	Ni	Cu
min.	0.01	0.5	0.60	-	-	-	22.0	12.0	-
max.	0.04	1.2	0.90	0.020	0.025	0.15	24.0	14.0	0.20

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm ²	595
Yield Stress/0.2% Proof Stress	N/mm ²	458
Elongation on 5D	%	39
Impact Energy CV @ +20°C as-welded	Joules	63

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

Storage and Re-drying

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

