



WB4560E M.M.A. WELDING ELECTRODE

Classifications AWS A5.4-06 : E309Mo-16

Product Description All positional, rutile coated, 309Mo stainless steel electrode giving a 316/316L deposit. Excellent deslag and outstanding welding properties.

Applications Used mainly for welding molybdenum bearing steels and wrought and cast alloys to Ferritic steels such as 316, 317 and 318 steel. This is known as a transition weld used for pressure vessel fabrications.

For cladding it deposits a 316-type deposit. It is also used for welding high carbon hardenable steel. 15-30FN range.

All-Weld Metal Composition (Weight %)		C	Mn	Si	S	P	Mo	Cr	Ni	Cu
min.		0.01	0.5	0.60	-	-	2.0	22.0	12.0	-
max.		0.03	1.2	0.90	0.020	0.025	3.0	24.0	14.0	0.10

Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength	N/mm ²	710
	Yield Stress/0.2% Proof Stress	N/mm ²	510
	Elongation on 5D	%	34
	Impact Energy CV @ +20°C as-welded	Joules	75

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 Packet	-	-	2	2	2	2	-
Approx. Pieces Per Kg	-	-	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 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

