



WB5505E M.M.A. WELDING ELECTRODE

Classifications	AWS A5.11-90 : ENiCrFe-3									
Product Description	Basic coated, nickel based electrode for welding nickel based steels, having excellent deslag and bead profile.									
Applications	Used mainly for welding and repairing nickel base alloys such as Inconel 601 [®] , Nimonic 75 [®] , Inconel 600 [®] and transition joints for use in pressure and cryogenic service. Such as 2CrMo to 316H material in conditions of long term creep. Used extensively in the power generation / petro-chemical industries									
All-Weld Metal Composition (Weight %)	C	Mn	Si	S	P	Ni	Cr	Cu	Nb + Ta	Fe
min.	-	5.0	-	-	-	59.0	13.0	-	1.0	-
max.	0.10	9.5	1.00	0.015	0.030	-	17.0	0.50	2.5	10.0
	Co	Ti								
min.	-	-								
max.	0.12	1.0								
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm ²	655			
	Yield Stress/0.2% Proof Stress					N/mm ²	390			
	Elongation on 4D					%	34			
	Impact Energy CV @ -196°C as-welded					Joules	90			

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	140	-
	max.	-	90	120	150	180	-
Packaging Information							
Kg Per Packet	-	-	5	5	5	5	-
Approx. Pieces Per Kg	-	-	28	19	12	8	-
Storage and Re-Drying	<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>						

Current Conditions AC OCV70 DC + and Welding Positions

