



WB5525E M.M.A. WELDING ELECTRODE

Classifications AWS A5.11 : ENiCrMo-5

Product Description Basic coated, high recovery electrode, having excellent deslag and bead profile. Manufactured from pure nickel core wire with a very rapid rate of work hardening.

Applications Used mainly for welding and repairing nickel base castings such as Alloy C-276 which are solution heat treated.

All-Weld Metal Composition (Weight %)		C	Mn	Si	S	P	Ni	Cr	Cu	Fe	W
min.		-	-	-	-	-	50.0	14.5	-	4.0	3.0
max.		0.10	1.0	1.0	0.030	0.040	-	16.5	0.50	7.0	4.5
		Co	V	Mo							
min.		-	-	15.0							
max.		2.5	0.35	17.0							

Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength	N/mm ²	690 min.
	Yield Stress/0.2% Proof Stress	N/mm ²	-
	Elongation on 4D	%	25 min.
	Impact Energy CV @ PWHT - solution treated @ 1120°C+WQ	Joules	-

Electrode Dia (mm)	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
Electrode Length (mm)	-	-	350	350	350	-	-
Current Range (Amps)	min.	-	60	80	100	-	-
	max.	-	90	120	150	-	-

Packaging Information

Kg Per Vac-Pac Packet	-	-	2	2	2	-	-
Approx. Pieces Per Kg	-	-	28	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 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

