



# WB56S M.M.A. WELDING ELECTRODE

**Classifications & Approvals**    AWS A5.1-04 : E7016-1

**Approvals**    LRS : 3YCMnLT40 ABS 4Y

**Product Description**    Thinly coated low hydrogen electrode for all-positional welding, yielding metal of very high impact values. Especially suitable for making full penetration welds in all positions such as pipe and overhead butt welds. Excellent de-slag & re-strike.

**Applications**    Recommend for the welding of unalloyed, micro-alloyed and low alloy steels within the medium tensile class. Excellent impact values down to -40°C, it is widely used for offshore fabrications. Eminently suitable for root pass welding on TKY Joints.

All-Weld Metal Composition (Weight %)		C	Mn	Si	S	P	Mo	Cr	Ni	V	Cu
min.		0.05	1.40	0.20	-	-	-	-	-	-	-
max.		0.10	1.60	0.50	0.015	0.020	0.05	0.05	0.10	0.02	0.08

Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength	N/mm <sup>2</sup>	524
	Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	424
	Elongation on 5D	%	31
	Impact Energy CV @ -46°C	Joules	164
	As-welded		

Electrode Dia (mm)	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm	
Electrode Length (mm)	-	-	350	450	450	450	450	
Current Range (Amps)	min.	-	-	60	105	140	160	220
	max.	-	-	90	140	170	200	250

Packaging Information	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
Kg Per Vac-Pac	-	-	2	2	2	2	2
Approx. Pieces Per Kg	-	-	50	26	17	11	8
Vac Pac Approx. Kg Carton	-	-	20	20	20	20	20

**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 if standard packaging**  
 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

