



WB76S M.M.A. WELDING ELECTRODE

Classifications & Approvals AWS A5.5-96 : E7018-G BSEN499-95 : E50 6 Mn1Ni B 3 2 H5 : LRS:C-MnLT60

Product Description Fully positional, basic coated, low hydrogen electrode depositing exceptionally clean metal of radiographic quality with excellent de-slag and re-strike. The addition of iron powder gives a recovery of ~ 120%.

Applications It is suitable for offshore constructions in steel such as BS4360-50D. Good impact values down to -60°C. Can be used for the welding of weathering steels, such as Cor-Ten A and Cor-Ten B. Excellent weldability on both AC and DC.

All-Weld Metal Composition (Weight %)		C	Mn	Si	S	P	Mo	Cr	Ni	V	Cu
	min.		0.03	1.00	0.15	-	-	-	-	0.6	-
max.		0.07	1.80	0.45	0.020	0.025	0.05	0.05	1.0	0.03	0.05

Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength	N/mm ²	559 **546
	Yield Stress/0.2% Proof Stress	N/mm ²	469 **455
	Elongation on 5D	%	29 **28
	Impact Energy CV @ -50°C	Joules	148 **146
	Impact Energy CV @ -60°C	Joules	95 **96
	as-welded		
**stress relieved @ 620°C/1 hour			

Electrode Dia (mm)		1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
Electrode Length (mm)		-	-	350	350 / 450	450	450	450
Current Range (Amps)	min.	-	-	60	90	130	170	230
	max.	-	-	90	135	180	230	280

Packaging Information

Kg Per Packet	-	-	2	2	2	2	2
Approx. Pieces Per Kg	-	-	44	21	15	10	7
Vac Pac Approx. Kg Carton	-	-	20	20	20	20	20

Storage

Storage and Re-Drying 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 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

