



WB8016-B5 M.M.A. WELDING ELECTRODE

Classifications	AWS A5.5-96 : E8016-B5									
Product Description	Fully positional, basic coated, low hydrogen electrode. Extremely smooth welding arc, with excellent welder appeal.									
Applications	Suitable for welding and repairing castings with the following typical chemistry:- 0.5%Cr, 1%Mo and 0.5%Cr 0.25%V creep-resisting steels. Scaling and creep resistance to 600°C.									
All-Weld Metal Composition (Weight %)	C	Mn	Si	S	P	Mo	Cr	Ni	V	Cu
min.	0.09	0.40	0.30	-	-	1.00	0.40	-	-	-
max.	0.12	0.70	0.60	0.020	0.025	1.25	0.60	0.05	0.03	0.03
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm ²	764			
	Yield Stress/0.2% Proof Stress					N/mm ²	637			
	Elongation on 5D					%	23			
	Impact Energy CV @ +20°C					Joules	78			
	Stress relieved @ 690°C/1Hr									

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.	-	70	110	135	160	220
	max.	-	100	145	180	220	300
Packaging Information							
Kg Per Packet	-	-	5	5	5	5	5
Approx. Pieces per Kg	-	-	44	21	14	10	7
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

