



# WB9109E M.M.A. WELDING ELECTRODE

<b>Classifications</b>	DIN 8555 : E1-UM-350							Hv350	
<b>Product Description</b>	All positional basic electrode, having excellent deslag and bead profile.								
<b>Applications</b>	Used mainly for surfacing giving a hardness value of 300/400 HV and is fully machinable.  Typical applications:- Tractor rollers, Great teeth & equipment, machine shafts & excavator equipment.								
<b>All-Weld Metal Composition (Weight %)</b>	C	Mn	Si	S	P	Cr			
<b>min.</b>	0.10	0.40	0.20	-	-	2.20			
<b>max.</b>	0.50	1.30	0.70	0.020	0.025	4.00			
<b>Typical All-Weld Metal Mechanical Properties</b>	Hardness – As-Welded - 3 layers							Hv	350-450 (HRC 33)

<b>Electrode Dia (mm)</b>	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm	
<b>Electrode Length (mm)</b>	-	-	-	450	450	450	-	
<b>Current Range (Amps)</b>	<b>min.</b>	-	-	-	110	140	160	-
	<b>max.</b>	-	-	-	145	180	220	-
<b>Packaging Information</b>								
<b>Kg Per Packet</b>	-	-	-	5	5	5	-	
<b>Approx. Pieces Per Kg</b>	-	-	-	23	15	10	-	
<b>Storage and Re-Drying</b>	<p><b>Storage</b> 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><b>Re-drying</b> 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

