WB9119E M.M.A. WELDING ELECTRODE

Classifications	BS EN 14700: 2014 Fe 8 Hv650
Product Description	All positional rutile coated electrode, depositing Martensitic weld metal with finely divided chromium carbides. Nominal recovery ~ 140%, excellent deslag and bead profile.
Applications	Applications Suitable for a wide range of overlay applications in the field of mining, agriculture etc. Weld metal deposits 600/700 HV and has a good resistance to impact, abrasion and erosion. Deposit can only be ground.

All-Weld Metal Composition (Weight %)

	C	Mn	Si	S	P	Cr	Mo	V
min.	0.45	0.10	0.20	-	-	7.0	1.00	0.60
max.	0.65	4.00	0.70	0.020	0.025	9.0	1.80	0.90

Typical All-Weld Metal Mechanical Properties

Hardness - As-Welded - 3 layers Hv 600-700

Electrode Dia (mm)		1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
Electrode Length (mm)		-	-	-	450	450	450	-
Current Range (Amps)	**min.**	-	-	-	110	140	160	-
	max.	-	-	-	145	180	220	-

Packaging Information

Kg Per Vac-Pac Packet	-	-	-	2	2	2	-
Approx. Pieces Per Kg	-	-	-	23	15	10	-

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 these electrodes become excessively damp re-dry @ 100°C for 1 hour.

Current Conditions AC OCV70 DC +/- and Welding Positions