



# WB9299E M.M.A. WELDING ELECTRODE

**Classification** ~AWS A5.13 : EFe-B5 Hv700

**Product Description** All positional electrode depositing a complex Martensitic alloy. Excellent deslag, bead profile and welder appeal.

**Applications** This electrode is used for both hot and cold work applications resisting softening up to 550°C and deposits 700/750HV.

**All-Weld Metal Composition (Weight %)**

	C	Mn	Si	S	P	Cr	Mo	V	W
min.	0.80	0.20	0.30	-	-	3.0	8.0	2.0	3.0
max.	1.30	0.30	0.80	0.020	0.025	5.0	10.0	3.0	5.0

**Typical All-Weld Metal Mechanical Properties** Hardness - As-Welded - 3 layers Hv 700-750

Electrode Dia (mm)	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm	
Electrode Length (mm)	-	-	-	450	450	450	450	
Current Range (Amps)	min.	-	-	-	120	140	160	210
	max.	-	-	-	145	180	220	240

**Packaging Information**

Kg Per Packet	-	-	-	2	2	2	2
Approx. Pieces Per Kg	-	-	-	16	11	7	5

**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**

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**

