WB9338E M.M.A. WELDING ELECTRODE

Classifications

AWS A5.13-80 : EFeMn-A

Product Description

All positional basic coated electrode depositing fully Austenitic weld metal. Nominal recovery of ~120%.

Applications

Normally used in environments where prime requirements are, resistance to impact and gouging abrasion. Can be used for welding and repairing manganese steel castings or for the overlay of other grades of steel. Typical applications include railway tracks, crossover points, digger teeth and excavation teeth. Deposits 250HV as welded and 500HV on work hardened.

All-Weld Metal Composition (Weight %)

	C	Mn	Si	S	P	Cr	Ni
min.	0.50	11.0	0.30	-	-	-	2.75
max.	0.90	16.0	0.60	0.020	0.025	0.20	6.00

Typical All-Weld Metal Mechanical Properties

Hardness - As-Welded - 3 layers	Hv	~250
Hardness - Work Hardens - 3 layers	Hv	~500

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

Storage and Re-baking

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.

POLARITY AND WELDING POSITIONS AC OCV70 DC +/-