



WB2020E M.M.A. WELDING ELECTRODE

Classifications	AWS A5.1-91 : E6013		BSEN499-95 : 639 : E4332 R21							
Product Description	Rutile electrode with a soft arc, low spatter and self lifting slag. Can be drawn out to very long weld lengths at a high travel speed thus minimising distortion. Fully positional.									
Applications	Mild and medium C-Mn steels up to 15mm thick with a UTS of 500 N/mm ² max.									
All-Weld Metal Composition (Weight %)	C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
min.	0.05	0.50	0.20	-	-	-	-	-	-	-
max.	0.11	0.90	0.40	0.020	0.025	0.20	0.05	0.02	0.050	0.050
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		498					
	Yield Stress/0.2% Proof Stress		N/mm ²		421					
	Elongation on 5D		%		26					
	Impact Energy CV @ 0°C		Joules		60					
	As-welded									

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.	-	80	100	140	190	230
	max.	-	110	140	180	230	280
Packaging Information							
Kg Per Packet	-	-	5	5	5	5	5
Approx. Pieces Per Kg	-	-	53	26	17	11	7

Storage and Re-baking	<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 If these electrodes become excessively damp re-dry @ 100°C for 1 hour.</p>
------------------------------	--

Current Conditions AC OCV70 DC +/- and Welding Positions

