



# WB4707E MMA WELDING ELECTRODE

<b>Classifications</b>	<b>AWS A5.4:</b> E310-17 <b>BS EN ISO 3581:</b> E 25 20 R 1 2																					
<b>Product Description</b>	All positional, rutile coated, stainless steel electrode giving a 25%Cr 20%Ni fully Austenitic deposit. Excellent deslag and outstanding welding properties.																					
<b>Applications</b>	Used mainly for welding and repairing 310 type stainless steels and dissimilar combinations of high temperature steels.  The weld deposit can be post-weld-heat-treated without loss of properties. Can be used for welding the following materials: - BS310S24, 310S31 & 310C24, ASTM310, 310S & CK20, DIN 1.4841, 1.4845 & 1.4840.																					
<b>All-Weld Metal Composition (Wt. %)</b>		C	Mn	Si	S	P	Mo	Cr	Ni	Cu												
<b>min.</b>		0.06	1.0	0.50	-	-	0.20	23.0	18.0	-												
<b>max.</b>		0.20	5.0	1.00	0.020	0.025	0.30	27.0	22.0	0.20												
<b>Typical All-Weld Metal Mechanical Properties</b>	<table> <tr> <td>Ultimate Tensile Strength</td> <td>N/mm<sup>2</sup></td> <td>650</td> </tr> <tr> <td>Yield Stress/0.2% Proof Stress</td> <td>N/mm<sup>2</sup></td> <td>375</td> </tr> <tr> <td>Elongation on 5D</td> <td>%</td> <td>27</td> </tr> <tr> <td>Impact Energy CV @ +20°C</td> <td>Joules</td> <td>75</td> </tr> </table> <p>As welded</p>										Ultimate Tensile Strength	N/mm <sup>2</sup>	650	Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	375	Elongation on 5D	%	27	Impact Energy CV @ +20°C	Joules	75
Ultimate Tensile Strength	N/mm <sup>2</sup>	650																				
Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	375																				
Elongation on 5D	%	27																				
Impact Energy CV @ +20°C	Joules	75																				

<b>Electrode Dia. (mm)</b>	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
<b>Electrode Length (mm)</b>	-	-	350	350	350	350	-
<b>Current Range (Amps)</b>	<b>min.</b>	-	60	80	100	130	-
	<b>max.</b>	-	100	140	170	210	-
<b>Packaging Information</b>							
<b>Kg Per Carton</b>	-	-	20	20	20	20	-
<b>Approx. Pieces Per Kg</b>	-	-	50	30	19	12	-
<b>Storage and Re-baking</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

