



WB76S MMA WELDING ELECTRODE

Classifications & Approvals	AWS A5.5: E7018-G H4R BS EN ISO 2560-A: E 50 6 Mn1Ni B 3 2 H5										
Product Description	Fully positional, basic coated, low hydrogen electrode depositing exceptionally clean metal of radiographic quality with excellent de-slag and re-strike. The addition of iron powder gives a recovery of ~ 120%.										
Applications	It is suitable for offshore constructions in steel such as BS4360-50D. Good impact values down to -60°C. Can be used for the welding of weathering steels, such as Cor-Ten A and Cor-Ten B. Excellent weldability on both AC and DC.										
All-Weld Metal Composition (Wt. %)		C	Mn	Si	S	P	Mo	Cr	Ni	V	Cu
min.		0.03	1.30	0.15	-	-	-	-	0.6	-	-
max.		0.07	1.70	0.45	0.020	0.025	0.05	0.05	1.0	0.03	0.05
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		631 **590						
	Yield Stress/0.2% Proof Stress		N/mm ²		556 **505						
	Elongation on 5D		%		29 **28						
	Impact Energy CV @ -50°C		Joules		148 **146						
	Impact Energy CV @ -60°C		Joules		95 **96						
	As welded										
	**Stress relieved @ 620°C/1 hour										

Electrode Dia. (mm)	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm	
Electrode Length (mm)	-	-	350	350 / 450	450	450	450	
Current Range (Amps)	min.	-	-	60	90	130	170	230
	max.	-	-	90	135	180	230	280
Packaging Information								
Kg Per Packet	-	-	2	2	2	2	2	
Approx. Pieces Per Kg	-	-	44	21	15	10	7	
Vac Pac Approx. Kg Carton	-	-	20	20	20	20	20	
Storage and Re-Drying	<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 4 cartons should be stacked on top of another.</p> <p>Re-drying if standard packaging 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

