



WB4444E MMA WELDING ELECTRODE

Classifications	AWS A5.4: E2594-16										
Product Description	All positional, semi-basic coated, super duplex stainless steel electrode. Excellent deslag, bead profile and outstanding welding properties.										
Applications	Used mainly for welding and repairing of duplex (Austenitic/Ferritic) alloys such as UNS S32760(wrought), UNS J99680(cast), Sandvik SAF 2507 and UR52N. Used extensively in the oil & gas industry and process pipework, risers, manifolds and the repair of matching castings. 30-60% ferrite with a PRE _N of >40.										
All-Weld Metal Composition (Wt. %)		C	Mn	Si	S	P	Mo	Cr	Ni	Cu	W
	min.	0.01	0.50	0.50	-	-	3.5	24.5	9.0	0.5	-
	max.	0.03	1.00	1.00	0.020	0.025	4.0	26.0	10.0	1.0	-
		N									
	min.	0.20									
	max.	0.30									
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		844						
	Yield Stress/0.2% Proof Stress		N/mm ²		680						
	Elongation on 5D		%		34						
	Impact Energy CV @ -50°C		Joules		79						
	As welded										

Electrode Dia. (mm)	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
Electrode Length (mm)	-	-	350	350	350	350	-
Current Range (Amps)	min.	-	60	80	100	130	-
	max.	-	100	150	180	210	-
Packaging Information							
Kg Per Packet	-	-	5	5	5	5	-
Approx. Pieces Per Kg	-	-	50	30	19	12	-
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 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

