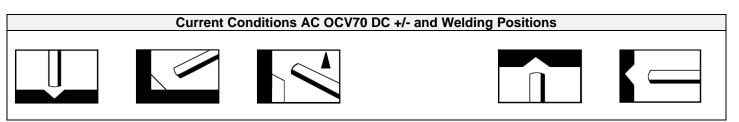


Classifications / Approvals	AWS A5	.1: E701	8-1H4R	EN ISO 2	560A: E4	65B32	2 H5	ABS	: 3YH	
Product Description	radiogra excellen	All positional, basic, low hydrogen electrode depositing weld metal of faultless radiography quality. The iron powder addition realises a recovery of ~ 120% and excellent impact properties are achieved down to -46°C. Excellent weld finish and a high degree of welder appeal, de-slag, re-strike etc.								
Applications	Recommend for the welding of mild/medium tensile steels up to grade 50D, having a tensile strength of 500 N/mm ² , Lloyds A and D ship steel, BS1449 plate and sheet. Its high deposition rate is most apparent when used as a fill after rooting with WB56S.									
All-Weld Metal Composition	6	Mie	Ċ	C	D	Ма	0.	NI:	V	Cu
(Weight %) min.	C 0.03	Mn 1.00	Si 0.20	S -	P -	Mo -	Cr -	Ni -	V -	Cu -
max.	0.08	1.50	0.50	0.030	0.030	0.18	0.06	0.10	0.02	0.05

Typical All-Weld Metal			Min.	Min. PWHT
Mechanical Properties			As welded	(600°C/1hr)
	Ultimate Tensile Strength	N/mm ²	570	520
	Yield Stress/0.2% Proof Stress	N/mm ²	480	460
	Elongation on 5D	%	26	30
	Impact Energy CVN @ -20°C	Joules	140	150
	Impact Energy CVN @ -30°C	Joules	130	140
	Impact Energy CVN @ -46°C	Joules	110	120
	Impact Energy CVN @ -51°C	Joules	75	90

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
	min.	-	-	70	100	130	160	230
Current Range (Amps)	max.	-	-	115	140	180	220	280
Packaging Informa	tion							
Kg Per Packet Approx. Pieces Per Kg Vac Pac Kg per Carton		- - -	- - -	2 44 20	2 21 20	2 15 20	2 10 20	2 7 20
Storage and Re-Drying 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. Re-drying if standard packaging Re-dry @ 350°C for 2 hours and then transfer to holding oven and hold @ 100°C-200°C, or 50°C-100°C in heated guiver.								



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