



# WB76S MMA WELDING ELECTRODE

<b>Classifications &amp; Approvals</b>	<b>AWS A5.5:</b> E7018-G H4R <b>BS EN ISO 2560-A:</b> E 50 6 Mn1Ni B 3 2 H5										
<b>Product Description</b>	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%.										
<b>Applications</b>	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.										
<b>All-Weld Metal Composition (Wt. %)</b>		C	Mn	Si	S	P	Mo	Cr	Ni	V	Cu
<b>min.</b>		0.03	1.30	0.15	-	-	-	-	0.6	-	-
<b>max.</b>		0.07	1.70	0.45	0.020	0.025	0.05	0.05	1.0	0.03	0.05
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength		N/mm <sup>2</sup>		631 **590						
	Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>		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										

<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 / 450	450	450	450	
<b>Current Range (Amps)</b>	<b>min.</b>	-	-	60	90	130	170	230
	<b>max.</b>	-	-	90	135	180	230	280
<b>Packaging Information</b>								
<b>Kg Per Packet</b>	-	-	2	2	2	2	2	
<b>Approx. Pieces Per Kg</b>	-	-	44	21	15	10	7	
<b>Vac Pac Approx. Kg Carton</b>	-	-	20	20	20	20	20	
<b>Storage and Re-Drying</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 stacked on top of another.</p> <p><b>Re-drying if standard packaging</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

