



# WB4555E MMA WELDING ELECTRODE

<b>Classifications</b>	<b>AWS A5.4:</b> E309L-16 <b>BS EN ISO 3581-A:</b> E23 12L R 1 2	
<b>Product Description</b>	All positional, rutile coated, 309L stainless steel electrode. Excellent deslag and outstanding welding properties.	
<b>Applications</b>	Used mainly for welding stainless steels and wrought and cast alloys to carbon steels such as 304 clad steels. This is known as a transition weld used largely for pressure vessel fabrications. For cladding it deposits a 308-type deposit on carbon steel and can be followed by 307-weld metal. 8-20FN range.	
<b>All-Weld Metal Composition (Wt. %)</b>		
	C	Mn
<b>min.</b>	0.01	0.5
<b>max.</b>	0.04	1.2
	Si	S
	0.60	-
	0.90	0.020
	P	Mo
	-	-
	0.025	0.15
	Cr	Ni
	22.0	12.0
	24.0	14.0
	Cu	
	-	0.20
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength	N/mm <sup>2</sup> 595
	Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup> 458
	Elongation on 5D	% 39
	Impact Energy CV @ +20°C	Joules 74
	Impact Energy CV @ -50°C	Joules 68
	As welded	

<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>	-	90	120	150	210	-
<b>Packaging Information</b>							
<b>Kg Per Packet</b>	-	-	5	5	5	5	-
<b>Approx. Pieces Per Kg</b>	-	-	50	30	19	12	-
<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 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

