



WB8016-G MMA WELDING ELECTRODE

Classifications	AWS A5.5: E8016-G BS EN ISO 2560-A: E 50 6 Mn1Ni B 12 H5										
Product Description	All positional, thinly coated, low hydrogen electrode with excellent sub-zero impact values. The weld metal has good mechanical properties both in the as welded and stress relieved condition. Excellent welder appeal.										
Applications	Developed for welding high yield steels (450N/mm ² min.). Used mainly for welding and repairing of high strength steels such as BS4360 55 E/F. WB8016-G exhibits excellent as-welded and post weld mechanical properties, including good CTOD values. Controlled Nickel addition ensures compliance with N.A.C.E. Used extensively on offshore fabrications / constructions.										
All-Weld Metal Composition (Weight %)		C	Mn	Si	S	P	Mo	Cr	Ni	V	Cu
min.		0.04	1.00	0.25	-	-	0.40	-	0.60	-	-
max.		0.08	1.50	0.65	0.020	0.025	0.65	0.05	1.00	0.01	0.05
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		*620		**578				
	Yield Stress/0.2% Proof Stress		N/mm ²		*518		**472				
	Elongation on 5D		%		*26		**31				
	Impact Energy CV @ -60°C		Joules		*63		**61				
	*As welded										
	**Stress-relieved @ 620°C/1Hr										

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	-
Current Range (Amps)	min.	-	55	80	110	180	-
	max.	-	85	140	180	230	-
Packaging Information							
Kg Per Packet	-	-	5	5	5	5	5
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 6 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

