



WB4606E MMA WELDING ELECTRODE

Classifications	AWS A5.4: E312-17 BSEN 3581-A: E29 9 R 1 2										
Product Description	All positional, rutile coated, stainless steel electrode for welding problem and dissimilar steels. Having excellent deslag and bead profile.										
Applications	Used mainly for welding and repairing steels of unknown specifications and for dissimilar welds between Ferritic and Austenitic steels. Also used for welding difficult to weld medium and high carbon steels, can also tolerate high rates of dilution. Typical grades include: - 709M40 (En19), 070M55, BS970 Part 1, 080M40 (En8), 070M55 (En9). Not recommended where PWHT is required or where materials will be subject to low temperature service.										
All-Weld Metal Composition (Weight %)		C	Mn	Si	S	P	Mo	Cr	Ni	Cu	V
	min.	0.05	0.5	0.60	-	-	0.20	27.0	8.0	-	-
	max.	0.12	2.5	1.20	0.020	0.025	0.40	31.0	12.0	0.20	0.15
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		812						
	Yield Stress/0.2% Proof Stress		N/mm ²		653						
	Elongation on 5D		%		19						
	Impact Energy CV @ +20°C		Joules		39						
	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	140	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

