



# WB9542E M.M.A. WELDING ELECTRODE

<b>Classifications</b>	AWS A5.13-80 : ECoCr-A										
<b>Product Description</b>	All positional electrode depositing a Stellite® 6 deposit. Good de-slag and general welder appeal.										
<b>Applications</b>	Used mainly for high temperature surfacing applications depositing a Stellite 6 430/470HV hardness.										
<b>All-Weld Metal Composition (Weight %)</b>		C	Mn	Si	S	P	Mo	Cr	Ni	Fe	W
	min.	0.7	-	-	-	-	-	25.0	-	-	3.0
	max.	1.4	2.0	2.0	0.020	0.025	1.0	32.0	3.0	5.0	6.0
		Co									
	min.	bal.									
	max.	-									
<b>Typical All-Weld Metal Mechanical Properties</b>	Hardness - As-Welded - 3 layers      Hv                      430-470										

<b>Electrode Dia (mm)</b>		1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
<b>Electrode Length (mm)</b>		-	-	-	450	450	450	450
<b>Current Range (Amps)</b>	min.	-	-	-	120	140	160	210
	max.	-	-	-	145	180	220	240
<b>Packaging Information</b>								
<b>Kg Per Packet</b>		-	-	-	5	5	5	5
<b>Approx. Pieces Per Kg</b>		-	-	-	16	11	7	5
<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

