



WB4414E MMA WELDING ELECTRODE

Classifications	AWS A5.4: E308H-17 BS EN ISO 3581: E 19 9 H R 1 2									
Product Description	All positional, rutile coated, stainless steel electrode depositing 308H Austenitic weld metal. Excellent deslag and outstanding welding properties.									
Applications	<p>Suitable for the repair and welding of 304H stainless steels with a controlled carbon content of 0.04-0.08% carbon and creep/oxidation 304H stainless steels.</p> <p>Used extensively in the following areas: - petrochemical and chemical process plant, cyclones and transfer lines operating in the 400-800°C temperature range.</p> <p>Controlled Ferrite 2-8FN.</p>									
All-Weld Metal Composition (Weight %)		C	Mn	Si	S	P	Mo	Cr	Ni	Cu
min.		0.04	0.5	0.60	-	-	-	18.0	9.0	-
max.		0.08	2.0	0.90	0.020	0.025	0.20	21.0	11.0	0.050
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		620					
	Yield Stress/0.2% Proof Stress		N/mm ²		430					
	Elongation on 5D		%		42					
	Impact Energy CV @ +20°C		Joules		80					
	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	170	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

