



WB5535E MMA WELDING ELECTRODE

Classification	AWS A5.11: ENiCrMo-3 BS EN ISO 14172: E Ni 6625 (NiCr22Mo9Nb)									
Product Description	WB5535E is a Ni-Cr-Mo type, MMA electrode. WB5535E is made on matching base core wire core wire. Excellent welder appeal in all positions.									
Applications	<p>WB5535E is optimised for welding in all positions. Particularly suited for pipe work. Extensively used in the offshore / marine industry. Excellent pitting resistance (PRE=50).</p> <p>Typical materials to be welded: Alloy 625: ASTM UNS N06625, BS NA21, DIN 2.4856, Inconel® 625 (Inco), Nicrofer 6020hMo, 6022hMo (VDM). High Nickel: Inconel® 601, Incoloy® 800H, 825 (Inco) and equivalents. Super Austenitic: UNS S31254, (254SMO), 904L and similar alloys. In addition to the above materials, WB625 is extensively used for overlaying carbon steels and combinations of the above.</p>									
All-Weld Metal Composition (Weight %)	C	Mn	Ni	Si	S	P	Nb	Fe	Mo	Cr
min.	0.02	0.50	58	-	-	-	3.15	-	8.0	20.0-
max.	0.05	1.00	-	0.60	0.015	0.015	4.15	2.0	10.0	23.0
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		760 min.					
	Yield Stress/0.2% Proof Stress		N/mm ²		400 min					
	Elongation on 4D		%		30 min.					
	Impact Energy CV @ -196°C		Joules		25 min.					

Electrode Dia (mm)	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
Electrode Length (mm)	-	-	260	300	350	350	-
Current Range (Amps)	min.	-	55	75	95	145	-
	max.	-	85	115	155	185	-
Packing Information							
Kg Per Packet	-	-	5	5	5	5	-
Approx. Pieces Per Kg	-	-	59	27	20	13	-
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 @ 300-350°C for 1-2 hours.</p>						

Current Conditions DC+ and Welding Positions

