

WB4405E M.M.A. WELDING ELECTRODE

Classifications	~AWS A5.4-92 : E308Mo-15										
Product Description	All positional, basic coated, 308Mo stainless steel electrode having excellent deslag and bead profile.										
Applications	Used for welding hardenable high strength steels, such as armour plate with typically 0.3C, 2Cr, 0.5Ni, 0.4Mo. Materials:- ARMOUR PLATE - MVEE 816 (MoD), Armax 816 (Swedish Steel) Compass B555 (Sleeman). 13%Mn (Hadfield's) steel Red diamond 14 (spartan redheugh), Abro M (Creusot). <0.4%C hardenable steels such as: BS970 709M40(En19), 817M40(En24), 826M40(En26), 897M39 (En40C). WEAR-RESISTANT STEELS such as:- Hardox 400 and 500 (Swedish Steel), ARQ360, A-R-COL (British Steel), Creusabro 4000, Abro 360 and 500 (Crusot), ABR 500 (Taysteel), Red Diamond 20, 21, 22 (spartan redburgh) Typical 20FN.										
All-Weld Metal Composition (Weight %)	C	Mn	Si	S	P	Mo	Cr	Ni	Cu		
	min. 0.04 max. 0.07	1.30 2.50	0.40 0.80	- 0.020	- 0.025	2.80 3.50	19.0 21.0	9.5 12.0	- 0.20		
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm ²	810				
	Yield Stress/0.2% Proof Stress					N/mm ²	560				
	Elongation on 5D					%	22				
	Impact Energy CV @ +20°C as-welded					Joules	80				

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.	-	90	120	150	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>						

POLARITY AND WELDING POSITIONS AC OCV70 DC +/-

