



## WB5505E MMA WELDING ELECTRODE

<b>Classifications</b>	<b>AWS A5.11: ENiCrFe-3</b>									
<b>Product Description</b>	Basic coated, nickel-based electrode for welding nickel-based steels, having excellent deslag and bead profile.									
<b>Applications</b>	Used mainly for welding and repairing nickel base alloys such as Inconel 82, 601©, Nimonic 75®, Inconel 600® and transition joints for use in pressure and cryogenic service. Such as 2CrMo to 316H material in conditions of long term creep.  Used extensively in the power generation / petro-chemical industries									
<b>All-Weld Metal Composition (Wt. %)</b>	C	Mn	Si	S	P	Ni	Cr	Cu	Nb + Ta	Fe
<b>min.</b>	-	5.0	-	-	-	59.0	13.0	-	1.0	-
<b>max.</b>	0.10	9.5	1.00	0.015	0.030	-	17.0	0.50	2.5	10.0
	Co	Ti								
<b>min.</b>	-	-								
<b>max.</b>	0.12	1.0								
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength					N/mm <sup>2</sup>		655		
	Yield Stress/0.2% Proof Stress					N/mm <sup>2</sup>		390		
	Elongation on 4D					%		34		
	Impact Energy CV @ -196°C					Joules		90		
	As welded									

<b>Electrode Dia. (mm)</b>	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
<b>Electrode Length (mm)</b>	-	-	350	350	350	350	-
<b>Current Range (Amps)</b>	<b>min.</b>	-	60	80	120	140	-
	<b>max.</b>	-	100	140	160	180	-
<b>Packaging Information</b>							
<b>Kg Per Packet</b>	-	-	5	5	5	5	-
<b>Approx. Pieces Per Kg</b>	-	-	28	19	12	8	-
<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 together.</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 DC+ and Welding Positions

