

WB9115E M.M.A. WELDING ELECTRODE

Classifications	BS EN 14700 : Z									
Product Description	All positional, low alloy, low hydrogen electrode, having excellent deslag and bead profile.									
Applications	WB9115E is used extensively in the foundry sector where matching analysis of cast and wrought base materials is of prime importance. WB9115E is normally used only when a full heat treatment is applied after welding, such as quench + temper or normalise + temper. This is carried out in order to achieve matching mechanical properties (YS/UTS). WB9115E is typically used for AISI 4130 material.									
All-Weld Metal Composition (Weight %)	C	Mn	Si	S	P	Cr	Mo	V	Ni	Cu
min.	0.28	0.50	0.30	-	-	0.80	0.15	-	-	-
max.	0.35	0.80	0.70	0.020	0.025	1.10	0.25	0.10	0.10	0.10
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		655 min.					
	Yield Stress/0.2% Proof Stress		N/mm ²		520 min.					
	Elongation on 5D		%		18 min.					
	Impact Energy CV @ -46°C		Joules		42 min.					
	Hardness		Vickers		250-350					
	Condition Q+T (900°C/1-6Hrs WQ + 635-650°C/1-6Hrs WQ)									

Electrode Dia (mm)	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
Electrode Length (mm)	-	-	350	450	450	450	450
Current Range (Amps)	min.	-	70	110	135	160	220
	max.	-	100	145	180	220	300
Packaging Information							
Kg Per Packet	-	-	5	5	5	5	5
Approx. Pieces Per Kg	-	-	44	21	15	10	7
Vac Pac Approx. Kg Carton	-	-	6	10.4	12	11.4	11.4
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 stacked 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 +/-

