

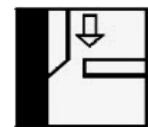


# WB2024E MMA WELDING ELECTRODE

<b>Classifications &amp; Approvals</b>	<b>AWS A5.1:</b> E6013 <b>BS EN ISO 2560-A:</b> E 42 2 R 12										
<b>Product Description</b>	Rutile coated electrode with a self lifting slag. Excellent strike and re-strike with virtually no tendency to stick. It is particularly suitable for vertical and overhead welding and has been developed primarily for users who prefer one electrode for all positions.										
<b>Applications</b>	Excellent all-positional general-purpose electrode for welding mild steel wrought iron and may be used on many grades of cast and medium tensile steel. Typical uses include the welding of storage tanks, pressure vessels, car bodies, ship building and for pipe fittings and pipe butt welds using the vertical-up technique.										
<b>All-Weld Metal Composition (Wt. %)</b>	C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu	
<b>min.</b>	0.04	0.30	0.10	-	-	-	-	-	-	-	-
<b>max.</b>	0.08	0.70	0.30	0.025	0.020	0.05	0.05	0.03	0.050	0.050	
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength		N/mm <sup>2</sup>		545						
	Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>		480						
	Elongation on 5D		%		26						
	Impact Energy CV @ -20°C		Joules		76						
	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	450	450	450	450
<b>Current Range (Amps)</b>	<b>min.</b>	-	50	100	120	180	220
	<b>max.</b>	-	90	145	180	240	285
<b>Packaging Information</b>							
<b>Kg Per Packet</b>	-	-	5	5	5	5	5
<b>Approx. Pieces Per Kg</b>	-	-	53	26	17	11	7
<b>Storage and Re-baking</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 on top of another.</p> <p><b>Re-drying</b> If these electrodes become excessively damp re-dry @ 100°C for 1 hour.</p>						

## Current Conditions OCV70 DC +/- and Welding Positions



**Approvals:** LR 3YS, ABS, CE