



WB4445E MMA WELDING ELECTRODE

Classifications	AWS A5.4: E2595-16										
Product Description	All positional, semi-basic coated, super duplex stainless steel electrode. Excellent deslag, bead profile and outstanding welding properties.										
Applications	Used mainly for welding and repairing of duplex (Austenitic/Ferritic) alloys such as UNS S32760(wrought), UNS J99680(cast), Sandvik SAF 2507 and UR52N. Used extensively in the oil & gas industry and process pipework, risers, manifolds, and the repair of matching Zeron 100 ® castings. 30-60% ferrite with a PRE _N of >40.										
All-Weld Metal Composition (Wt. %)		C	Mn	Si	S	P	Mo	Cr	Ni	Cu	W
min.		-	-	-	-	-	2.5	24.0	8.0	0.4	0.4
max.		0.04	2.50	1.20	0.025	0.030	4.5	27.0	10.5	1.5	1.0
		N									
min.		0.20									
max.		0.30									
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		873						
	Yield Stress/0.2% Proof Stress		N/mm ²		703						
	Elongation on 5D		%		30						
	Impact Energy CV @ -50°C		Joules		>29						
	As welded										

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 4 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>						

Current Conditions AC OCV70 DC + and Welding Positions

