

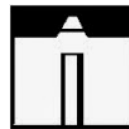
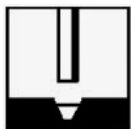


## WB56S MMA WELDING ELECTRODE

<b>Classifications</b>	<b>AWS A5.1:</b> E7016-1 H4 R <b>BS EN ISO 2560-A:</b> E 42 5 B1 2 H5									
<b>Product Description</b>	Thinly coated low hydrogen electrode for all-positional welding, yielding metal of very high impact values. Especially suitable for making full penetration welds in all positions such as pipe and overhead butt welds. Excellent de-slag & re-strike.									
<b>Applications</b>	Recommend for the welding of unalloyed, micro-alloyed and low alloy steels within the medium tensile class. Excellent impact values down to -50°C, it is widely used for offshore fabrications. Eminently suitable for root pass welding on TKY Joints.									
<b>All-Weld Metal Composition (Wt. %)</b>										
	C	Mn	Si	S	P	Mo	Cr	Ni	V	Cu
<b>min.</b>	0.05	1.40	0.20	-	-	-	-	-	-	-
<b>max.</b>	0.10	1.60	0.50	0.015	0.020	0.05	0.05	0.10	0.02	0.08
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength				N/mm <sup>2</sup>		*594			
	Yield Stress/0.2% Proof Stress				N/mm <sup>2</sup>		*477			
	Elongation on 5D				%		*27			
	Impact Energy CV @ -50°C				Joules		*107			
	As welded						*Actual Results			

<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>	-	-	60	90	140	160	220
	<b>max.</b>	-	-	90	140	180	200	250
<b>Packaging Information</b>								
<b>Kg Per Packet</b>		-	-	5	5	5	5	5
<b>Approx. Pieces Per Kg</b>		-	-	50	26	17	11	8
<b>Vac Pac Approx. Kg Carton</b>		-	-	20.0	20.0	20.0	20.0	20.0
<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 4 cartons should be staked on top of another.</p> <p><b>Re-drying if standard packaging</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 AC OCV70 DC +/- and Welding Positions



**Approvals:** ABS, LR (3Ym)