



## WB4404E MMA WELDING ELECTRODE

<b>Classifications</b>	<b>AWS A5.4:</b> E308L-17 <b>BS EN ISO 3581-A:</b> E19 9 L R 1 2																													
<b>Product Description</b>	All positional stainless steel electrode depositing 308L Austenitic weld metal. Excellent deslag and outstanding welding properties with low spatter levels.																													
<b>Applications</b>	Suitable for the repair and welding of wrought and cast alloys such as 304, 304L, C12 and 304.S.62 . Suitable for use in corrosive environments up to 400°C. Also suitable for welding type 321 stabilised grade, in addition to types 301, 302 and 303. Typical applications :- food, pressure vessels, valves and general stainless steel engineering. Ferrite in the 3-8 FN range.																													
<b>All-Weld Metal Composition (Wt. %)</b>		C	Mn	Si	S	P	Mo	Cr	Ni	Cu																				
<b>min.</b>		0.01	0.50	0.60	-	-	-	18.5	9.5	-																				
<b>max.</b>		0.03	1.20	0.90	0.020	0.025	0.10	20.0	11.0	0.10																				
<b>Typical All-Weld Metal Mechanical Properties</b>	<table border="0"> <tr> <td>Ultimate Tensile Strength</td> <td>N/mm<sup>2</sup></td> <td>Typical</td> <td>580</td> </tr> <tr> <td>Yield Stress/0.2% Proof Stress</td> <td>N/mm<sup>2</sup></td> <td></td> <td>420</td> </tr> <tr> <td>Elongation on 5D</td> <td>%</td> <td></td> <td>42</td> </tr> <tr> <td>Impact Energy CV @ -20°C</td> <td>Joules</td> <td></td> <td>95</td> </tr> <tr> <td colspan="4">As welded</td> </tr> </table>										Ultimate Tensile Strength	N/mm <sup>2</sup>	Typical	580	Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>		420	Elongation on 5D	%		42	Impact Energy CV @ -20°C	Joules		95	As welded			
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<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	100	120	-
	<b>max.</b>	-	100	120	180	230	-
<b>Packaging Information (available in vac pacs)</b>							
<b>Kg Per Packet</b>	-	-	5	5	5	5	-
<b>Approx. Pieces Per Kg</b>	-	-	50	30	19	12	-
<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 stacked on top of another.</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 AC OCV70 DC +/- and Welding Positions

