



WB2116E M.M.A. WELDING ELECTRODE

Classifications & Approvals	AWS A5.1-91 : E7016-1 BSEN 499-95 : E424B12H5 LRS : 3YCMnLT40									
Product Description	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.									
Applications	Recommend for the welding of unalloyed, micro-alloyed and low alloy steels within the medium tensile class. Excellent impact values down to -60°C, it is widely used for offshore fabrications. Eminently suitable for root pass welding.									
All-Weld Metal Composition (Weight %)	C	Mn	Si	S	P	Mo	Cr	Ni	V	Cu
min.	0.05	0.50	0.20	-	-	-	-	-	-	-
max.	0.10	1.20	0.60	0.015	0.020	0.05	0.05	0.10	0.02	0.08
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		580					
	Yield Stress/0.2% Proof Stress		N/mm ²		510					
	Elongation on 5D		%		32					
	Impact Energy CV @ -40°C		Joules		220					
	Impact Energy CV @ -50°C		Joules		100					
	Impact Energy CV @ -60°C		Joules		55					
	As-welded									

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.	-	60	105	140	160	220
	max.	-	90	140	170	200	250
Packaging Information							
Kg Per Packet	-	-	5	5	5	5	5
Approx. Pieces Per Kg	-	-	50	26	17	11	8
Vac Pac Approx. Kg Carton	-	-	6.8	10.2	10.8	11.1	11.4
Storage and Re-Drying	<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 staked on top of another.</p> <p>Re-drying if standard packaging 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

