



# WB4303E M.M.A. WELDING ELECTRODE

<b>Classifications</b>	There are no national / international specifications that cover this product.									
<b>Product Description</b>	Rutile coated, high strength, Martensitic, precipitation hardening stainless steel. Manufactured on high quality, mild steel core wire. Exceptional deslag and arc stability. This electrode produces a recovery of ~180%.									
<b>Applications</b>	Suitable for the repair and welding of high strength Martensitic precipitation hardening steels. Such as ASTM type 630, 17-4PH(Armco Steel), Custom 630 (Carpenter Technology), ASTM A747 CB-7Cu-1, CB-7Cu-2(cast alloys),FV520 and alloy 450 types.									
<b>All-Weld Metal Composition (Weight %)</b>		C	Mn	Si	S	P	Mo	Cr	Ni	Cu
<b>min.</b>		0.05	0.40	0.10	-	-	-	14.0	3.5	3.0-
<b>max.</b>		0.10	1.00	0.30	0.020	0.025	0.05	16.5	4.5	4.0
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength		N/mm <sup>2</sup>			-				
	Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>			-				
	Elongation on 5D		%			-				
	Impact Energy CV @		Joules			-				

<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>	-	-	70	90	120	160	-
	<b>max.</b>	-	-	110	140	180	220	-
<b>Packaging Information</b>								
<b>Kg Per Packet</b>		-	-	5	5	5	5	-
<b>Approx. Pieces Per Kg</b>		-	-	36	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> 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

