



WB5515E M.M.A. WELDING ELECTRODE

Classifications	AWS A5.11-90 : ENiCrFe-2									
Product Description	Basic coated, nickel based electrode for welding nickel based steels, having excellent deslag and bead profile.									
Applications	Used mainly for welding and repairing nickel base alloys such as Inconel 600®, Incoloy 800® Incoloy DS, Nilo, Brightray. Also utilised for cryogenic 3-9% nickel steels. Used extensively in the furnace equipment & repair / petro-chemical industries									
All-Weld Metal Composition (Weight %)	C	Mn	Si	S	P	Ni	Cr	Cu	Nb + Ta	Fe
min.	-	1.0	-	-	-	62.0	13.0	-	1.5	-
max.	0.10	3.5	0.75	0.015	0.030	-	17.0	0.50	3.5	12.0
	Co	Ti	Mo							
min.	-	-	1.0							
max.	0.12	1.0	2.5							
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm ²	650			
	Yield Stress/0.2% Proof Stress					N/mm ²	405			
	Elongation on 4D					%	34			
	Impact Energy CV @ -196°C as-welded					Joules	86			

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	140	-
	max.	-	90	120	150	180	-
Packaging Information							
Kg Per Packet	-	-	5	5	5	5	-
Approx. Pieces Per Kg	-	-	28	19	12	8	-
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 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

