WB5535E MMA WELDING ELECTRODE

Classification	**AWS A5.11:** ENiCrMo-3 **BS EN ISO 14172:** E Ni 6625 (NiCr22Mo9Nb)
Product Description	WB5535Eis a Ni-Cr-Mo type, MMA electrode. WB5535E is made on matching base core wire core wire. Excellent welder appeal in all positions.
Applications	WB5535E is optimised for welding in all positions. Particularly suited for pipe work. Extensively used in the offshore / marine industry. Excellent pitting resistance (PRE=50). Typical materials to be welded: Alloy 625: ASTM UNS N06625, BS NA21, DIN 2.4856, Inconel® 625 (Inco), Nicrofer 6020hMo, 6022hMo (VDM). High Nickel: Inconel ® 601, Incoloy ® 800H, 825 (Inco) and equivalents. Super Austenitic: UNS S31254, (254SMO), 904L and similar alloys. In addition to the above materials, WB625 is extensively used for overlaying carbon steels and combinations of the above.

All-Weld Metal Composition (Weight %)	C	Mn	Ni	Si	S	P	Nb	Fe	Mo	Cr
min.	0.02	0.50	58	-	-	-	3.15	-	8.0	20.0-
max.	0.05	1.00	-	0.60	0.015	0.015	4.15	2.0	10.0	23.0

Typical All-Weld Metal Mechanical Properties		
Ultimate Tensile Strength	N/mm²	760 min.
Yield Stress/0.2% Proof Stress	N/mm²	400 min
Elongation on 4D	%	30 min.
Impact Energy CV @ -196°C	Joules	25 min.

Electrode Dia (mm)		1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
Electrode Length (mm)		-	-	260	300	350	350	-
Current Range (Amps)	**min.**	-	-	55	75	95	145	-
	max.	-	-	85	115	155	185	-
Packing Information								
Kg Per Packet		-	-	5	5	5	5	-
Approx. Pieces Per Kg		-	-	59	27	20	13	

Storage and Re-baking	**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 4 cartons should be staked on top of another. **Re-drying** Re-dry @ 300-350°C for 1-2 hours.

Current Conditions DC+ and Welding Positions