



WB5505E MMA WELDING ELECTRODE

Classifications	AWS A5.11: ENiCrFe-3										
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 82, 601©, Nimonic 75®, Inconel 600® and transition joints for use in pressure and cryogenic service. Such as 2CrMo to 316H material in conditions of long term creep. Used extensively in the power generation / petro-chemical industries										
All-Weld Metal Composition (Wt. %)		C	Mn	Si	S	P	Ni	Cr	Cu	Nb + Ta	Fe
min.		-	5.0	-	-	-	59.0	13.0	-	1.0	-
max.		0.10	9.5	1.00	0.015	0.030	-	17.0	0.50	2.5	10.0
		Co	Ti								
min.		-	-								
max.		0.12	1.0								
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		655						
	Yield Stress/0.2% Proof Stress		N/mm ²		390						
	Elongation on 4D		%		34						
	Impact Energy CV @ -196°C		Joules		90						
	As welded										

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	120	140	-
	max.	-	100	140	160	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 4 cartons should be staked together.</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 DC+ and Welding Positions

