



WB4545E-15 MMA WELDING ELECTRODE

Classifications	AWS A5.4: E2209-15 BS EN ISO 3581-A: E22 9 3 N L B										
Product Description	All positional, basic coated, duplex stainless steel electrode, Excellent welding characteristics.										
Applications	<p>This electrode finds use in the fabrication and repair of offshore installations and pipework by virtue of its high strength and corrosion resistance, can be used for welding SAF2205, DINI.4662, Avesta 223, Sandvik 223, UNS1803 and ASTM A182 Gr. F51.</p> <p>WB4545E is extensively used for the repair of "standard" duplex castings and yields excellent mechanical properties in the as-welded condition.</p> <p>Duplex structure of ~ 60/40 austenite/ferrite gives a pitting resistance equivalent of ~38.</p>										
All-Weld Metal Composition (Wt. %)	C	Mn	Si	S	P	Mo	Cr	Ni	Cu	N	
min.	0.01	0.5	0.30	-	-	2.5	21.5	9.0	-	0.08	
max.	0.03	1.2	0.70	0.020	0.025	3.5	23.5	10.5	0.20	0.20	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		768		**792				
	Yield Stress/0.2% Proof Stress		N/mm ²		577		**585				
	Elongation on 5D		%		32		**32				
	Impact Energy CV @ -46°C		Joules		52		**78 (@-50°C)				
	As welded, **PWHT										

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	130	-
	max.	-	100	140	180	210	-
Packaging Information							
Kg Per Packet	-	-	5	5	5	5	-
Approx. Pieces Per Kg	-	-	50	30	19	12	-

Storage and Re-baking	<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 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>
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Current Conditions AC OCV70 DC +/- and Welding Positions

