



WB4404E MMA WELDING ELECTRODE

Classifications	AWS A5.4: E308L-17 BS EN ISO 3581-A: E19 9 L R 1 2																													
Product Description	All positional stainless steel electrode depositing 308L Austenitic weld metal. Excellent deslag and outstanding welding properties with low spatter levels.																													
Applications	Suitable for the repair and welding of wrought and cast alloys such as 304, 304L, C12 and 304.S.62 . Suitable for use in corrosive environments up to 400°C. Also suitable for welding type 321 stabilised grade, in addition to types 301, 302 and 303. Typical applications :- food, pressure vessels, valves and general stainless steel engineering. Ferrite in the 3-8 FN range.																													
All-Weld Metal Composition (Wt. %)		C	Mn	Si	S	P	Mo	Cr	Ni	Cu																				
min.		0.01	0.50	0.60	-	-	-	18.5	9.5	-																				
max.		0.03	1.20	0.90	0.020	0.025	0.10	20.0	11.0	0.10																				
Typical All-Weld Metal Mechanical Properties		<table border="0"> <tr> <td>Ultimate Tensile Strength</td> <td>N/mm²</td> <td>Typical</td> <td>580</td> </tr> <tr> <td>Yield Stress/0.2% Proof Stress</td> <td>N/mm²</td> <td></td> <td>420</td> </tr> <tr> <td>Elongation on 5D</td> <td>%</td> <td></td> <td>42</td> </tr> <tr> <td>Impact Energy CV @ -20°C</td> <td>Joules</td> <td></td> <td>95</td> </tr> <tr> <td>As welded</td> <td></td> <td></td> <td></td> </tr> </table>									Ultimate Tensile Strength	N/mm ²	Typical	580	Yield Stress/0.2% Proof Stress	N/mm ²		420	Elongation on 5D	%		42	Impact Energy CV @ -20°C	Joules		95	As welded			
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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	120	-
	max.	-	-	100	120	180	230	-
Packaging Information (available in vac pacs)								
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 stacked 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

