



WB9338E M.M.A. WELDING ELECTRODE

Classifications	AWS A5.13-80 : EFeMn-A , ~EN 14700:2005 E Fe9							
Product Description	All positional basic coated electrode depositing fully Austenitic weld metal. Nominal recovery of ~120%.							
Applications	Normally used in environments where prime requirements are, resistance to impact and gouging abrasion. Can be used for welding and repairing manganese steel castings or for the overlay of other grades of steel. Typical applications include railway tracks, crossover points, digger teeth and excavation teeth. Deposits 250HV as welded and 500HV on work hardened.							
All-Weld Metal Composition (Weight %)								
min.	C	Mn	Si	S	P	Cr	Ni	
max.	0.50	11.0	0.30	-	-	-	2.75	
	0.90	16.0	0.60	0.020	0.025	0.20	6.00	
Typical All-Weld Metal Mechanical Properties	Hardness - As-Welded - 3 layers Hv ~250 Hardness - Work Hardens - 3 layers Hv ~500							

Electrode Dia (mm)	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
Electrode Length (mm)	-	-	350	350	350	450	-
Current Range (Amps)	min.	-	80	120	140	160	-
	max.	-	110	145	180	220	-
Packaging Information							
Kg Per Vac Pack	-	-	6.4	8.0	8.0	12.0	-
Approx. Pieces Per Kg	-	-	21	16	11	7	-
Storage and Re-baking	<p>Storage It is recommended that the WB range of electrodes is 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 If required, 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>						

POLARITY AND WELDING POSITIONS AC OCV70 DC +/-

