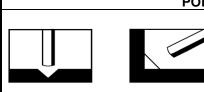


WB9338E M.M.A. WELDING ELECTRODE

Classifications	AWS A5	AWS A5.13-80 : EFeMn-A , ~EN 14700:2005 E Fe9						E Fe9		
Product Description		All positional basic coated electrode depositing fully Austenitic weld metal. Nominal recovery of ~120%.								
Applications	and gou castings railway	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 %)	С	Mn	Si	S	Р	Cr	Ni			
min		11.0	0.30	-	-	-	2.75			
max	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 Hardness - Work Hardens - 3 layers				Hv Hv	~250 ~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	-		
.	min.	-	-	80	120	140	160	-		
Current Range (Amps)	max.	-	-	110	145	180	220	-		
Packaging Informat	ion									
Kg Per Vac Pack Approx. Pieces Per Kg		-	-	6.4 21	8.0 16	8.0 11	12.0 7	-		
Storage and Re-bak	sing	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. 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.								



POLARITY AND WELDING POSITIONS AC OCV70 DC +/-

