



WB4505E MMA WELDING ELECTRODE

Classifications	AWS A5.4: E316L-17 BS EN ISO 3581-A: E19 12 3L R 1 2									
Product Description	All positional, rutile coated, Austenitic stainless steel electrode depositing Molybdenum bearing weld metal. Excellent deslag and outstanding welding properties.									
Applications	Used mainly for welding and repairing 316L stainless steels and wrought and cast alloys 316, S62, CF3M, CF8M and 316C12 it is also suitable for the mixed welding of 304L, 316L, 321 and 347 stainless steels. Ferrite in 3-10 FN range. Corrosion resistant up to 400°C.									
All-Weld Metal Composition (Weight %)	C	Mn	Si	S	P	Mo	Cr	Ni	Cu	
	min. 0.01 max. 0.03	0.50 1.20	0.40 0.95	- 0.020	- 0.028	2.5 3.0	18.0 20.0	11.0 14.0	- 0.20	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm ²	607			
	Yield Stress/0.2% Proof Stress					N/mm ²	485			
	Elongation on 5D					%	38			
	Impact Energy CV @ +20°C					Joules	76			
	Impact Energy CV @ -50°C					Joules	51			
	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	100	130	-
	max.	-	90	110	150	210	-
Packaging Information (available in vac pacs)							
Kg Per Packet	-	-	2	2	2	2	-
Approx. Pieces Per Kg	-	-	48	29	18	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°C - 200°C, or 50-100°C in heated quiver.</p>						

Current Conditions AC OCV70 DC +/- and Welding Positions

