



WB4707E MMA WELDING ELECTRODE

Classifications	AWS A5.4: E310-17 BS EN ISO 3581: E 25 20 R 1 2										
Product Description	All positional, rutile coated, stainless steel electrode giving a 25%Cr 20%Ni fully Austenitic deposit. Excellent deslag and outstanding welding properties.										
Applications	Used mainly for welding and repairing 310 type stainless steels and dissimilar combinations of high temperature steels. The weld deposit can be post-weld-heat-treated without loss of properties. Can be used for welding the following materials: - BS310S24, 310S31 & 310C24, ASTM310, 310S & CK20, DIN 1.4841, 1.4845 & 1.4840.										
All-Weld Metal Composition (Wt. %)	C	Mn	Si	S	P	Mo	Cr	Ni	Cu		
min.	0.06	1.0	0.50	-	-	0.20	23.0	18.0	-		
max.	0.20	5.0	1.00	0.020	0.025	0.30	27.0	22.0	0.20		
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		650						
	Yield Stress/0.2% Proof Stress		N/mm ²		375						
	Elongation on 5D		%		27						
	Impact Energy CV @ +20°C		Joules		75						
	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.	-	100	140	170	210	-
Packaging Information							
Kg Per Carton	-	-	20	20	20	20	-
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>						

Current Conditions AC OCV70 DC +/- and Welding Positions

