WB9119E MMA WELDING ELECTRODE

Classifications	**BS EN 14700:** E Fe6 Hv700
Product Description	All positional rutile coated electrode, depositing Martensitic weld metal with finely divided chromium carbides. Nominal recovery ~ 140%, excellent deslag and bead profile.
Applications	Suitable for a wide range of overlay applications in the field of mining, agriculture etc. In addition is extensively used in sintering plant repairs. Weld metal deposits 650/750 HV and has a good resistance to impact, abrasion and erosion. Deposit can only be ground.

All-Weld Metal Composition (Weight %)	C	Mn	Si	S	P	Cr	Mo	V		
min.	0.45	0.10	0.20	-	-	6.5	1.00	0.60		
max.	0.65	4.00	0.80	0.020	0.025	9.0	1.80	0.90		

Typical All-Weld Metal Mechanical Properties	Hardness - As-Welded - 3 layers Hv 650-750

Electrode Dia (mm)		1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
Electrode Length (mm)		-	-	-	450	450	450	-
Current Range (Amps)	**min.**	-	-	-	100	120	140	-
	max.	-	-	-	150	180	220	-
Packaging Information								
Kg Per Packet		-	-	-	5	5	5	-
Approx. Pieces Per Kg		-	-	-	23	15	10	-

Storage and Re-Drying	**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. **Re-drying** If these electrodes become excessively damp re-dry @ 100°C for 1 hour.

Current Conditions DC- and Welding Positions