WB1600E MMA WELDING ELECTRODE

Classification	**AWS A5.15:** ENiFe-CI **BS EN ISO 1071:** E C NiFe-C1 3
Product Description	High strength weld for cast iron. Deposits a Nickel-Iron alloy. Deposit is fully machinable. Narrow fusion zone, thus minimal HAZ. Smooth, quiet welding arc.
Application	Used mainly for welding nodular graphite or spheroidal graphite (SG) cast irons. WB1600E is also suitable for welding the austenitic Ni-Resist irons and alloy cast irons.

All-Weld Metal Composition (Wt. %)	C	Mn	Ni	Si	S	P	Al	Cu+Ag	Fe
min.	1.0	0.50	45.0	0.50	-	-	-	-	Bal.
max.	2.0	2.50	60.0	4.00	0.02	0.02	0.10	0.10	

Typical All-Weld Metal Mechanical Properties		
Ultimate Tensile Strength	N/mm²	495
Yield Stress/0.2% Proof Stress	N/mm²	380
Elongation on 5D	%	10
Impact Energy CV @	Joules	-
Hardness	Hv10	170

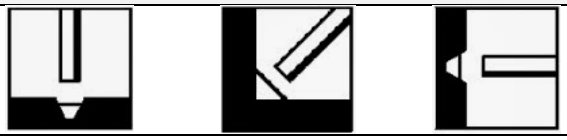
Electrode Dia (mm)		1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
Electrode Length (mm)		-	-	350	350	350	350	-
Current Range (Amps)	**min.**	-	-	50	80	90	140	-
	max.	-	-	80	120	160	180	-
Packing Information								
Kg Per Packet		-	-	5	5	5	5	-
Approx. Pieces Per Kg		-	-	50	32	21	13	

Storage and Re-baking

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 damp re-dry @ 180°C for 1 hour.

Current Conditions AC OCV70 DC + and Welding Positions



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