

WB9229E M.M.A. WELDING ELECTRODE

Classifications	BS EN 14700 : E Z Fe14 Hv850									
Product Description	Rutile coated electrode giving ~ 200% recovery for conditions of severe abrasion. Optimum abrasion resistance due to chromium carbide particles in a ledeburitic matrix 850HV.									
Applications	This electrode should be used in applications where conditions of severe abrasion and light to medium impact prevail. Due to its high chromium content it exhibits scaling resistance up to 850°C. Used widely in Agriculture, Quarrying, Mining and Foundries. Deposit can only be ground.									
All-Weld Metal Composition (Weight %)										
	C	Mn	Si	S	P	Cr	Mo	V	Ni	
min.	2.00	0.50	0.30	-	-	32.0	0.40	0.20	0.10	
max.	5.00	1.00	0.70	0.020	0.025	38.0	0.80	0.50	0.20	
Typical All-Weld Metal Mechanical Properties	Hardness - As-Welded - 3 layers Hv 800-900									

Electrode Dia (mm)		1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
Electrode Length (mm)		-	-	-	450	450	450	450
Current Range (Amps)	min.	-	-	-	120	140	160	210
	max.	-	-	-	145	180	220	240
Packaging Information								
Kg Per Packet		-	-	-	5	5	5	5
Approx. Pieces Per Kg		-	-	-	16	11	7	5
Storage and Re-Drying	<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 6 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

