



WB6114 FLUX CORED WELDING WIRE

Classifications

AWS A5.20-95 : E71-T1

BSEN758-97 : T45 2 PM1 H5

Product Description

Rutile, copper coated, tubular, flux cored, welding wire. Fully positional.

Applications

WB6114 is ideal for general fabrication applications. Excellent deposition rates due to metal powder technology.

Tubular technology & copper coating ensures very low weld metal hydrogen levels (<3ml/100g) coupled with excellent current tip transfer. Excellent welder appeal including deslag and low spatter levels.

Recommend for the welding of mild/medium tensile steels up to grade 50D, having a tensile strength of ~500 N/mm², Lloyds A and D ship steel, BS1449 plate and sheet.

Wire Composition(Weight %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
min.	0.04	1.10	0.30	-	-	-	-	-	-	-
max.	0.08	1.65	0.65	0.025	0.025	0.10	0.50	0.10	0.30	0.10

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm ²	510-660
Yield Stress/0.2% Proof Stress	N/mm ²	410 min.
Elongation on 5D	%	22 min.
Impact Energy CV @ -20°C as-welded	Joules	47 min.

Wire Dia (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	150	160	180	-	-
	max.	-	-	240	260	300	-	-
Volt Range (Volts)	min.	-	-	17	18	20	-	-
	max.	-	-	24	26	29	-	-

Packaging Information

Kg Per Reel	-	-	16	16	16	-	-
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Storage

Storage

It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.

Gases

Gas

CO₂ or Argon/CO₂ mixture

Flow Rate

12-16 l/min

Current Conditions DC+ and Welding Positions

