



# WB6132-R FLUX CORED WELDING WIRE

**Classifications** AWS A5.29-80 : E111-T1-G M J H4 : EN ISO 18276-A : T69 4 Z PM1H5  
DNV IVY69MS(H5)

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

**Applications** WB6132-R is ideal for general fabrication applications and high integrity applications. 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.  
Widely used for the welding of steels with a tensile strength of 750/850 N/mm<sup>2</sup>, such as RQT600, HY80, NAXTRA 70 and T1.

Wire Composition(Weight %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
min.		0.04	1.10	0.30	-	-	-	1.75	0.30	-	-
max.		0.08	1.75	0.60	0.025	0.025	0.15	2.4	0.60	0.30	0.10

Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm <sup>2</sup>	*760-900	**740-840
		Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>	*690 min.
	Elongation on 5D		%	*15 min.	**16 min.
	Impact Energy CV @ -51°C		Joules	*27 min.	**47J min. Ave.(-60°C)
	*as-welded				
	** stress relieved @690°C/1 Hr				

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

## Packaging Information

Kg Per Reel	0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
	-	-	16	16	16	-	-

**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**  
CO<sub>2</sub> or Argon/CO<sub>2</sub> mixture

**Flow Rate**  
12-16 l/min

## Current Conditions DC+ and Welding Positions

