



WB6132 FLUX CORED WELDING WIRE

Classifications	AWS A5.29-80 : E110-T5-K4										
Product Description	Basic, copper coated, tubular, flux cored, welding wire. Fully positional.										
Applications	WB6132 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 ² , 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	-	-	0.30	2.0	0.30	-	-	
max.	0.08	1.75	0.60	0.025	0.025	0.50	2.4	0.60	0.30	0.10	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm ²	*760-900		**740-840		
	Yield Stress/0.2% Proof Stress					N/mm ²	*690 min.		**670 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
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	-	-
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 ₂ or Argon/CO ₂ mixture							
	Flow Rate 12-16 l/min							

Current Conditions DC+ and Welding Positions

