

# WB6154-MC FLUX CORED WELDING WIRE

<b>Classifications</b>	DIN 8555-83 : MSG6-60      BSEN 14700-2000 : T Fe8									
<b>Product Description</b>	Metal-cored, copper coated, hardfacing, tubular, flux cored, welding wire.									
<b>Applications</b>	<p>WB6154-MC is a metal-cored, medium alloy hardfacing , flux cored wire. Easily controllable weld pool, excellent welding properties with no need to de-slag. This allows welding with high currents, consequently yielding a high deposition rate. Tubular technology &amp; copper coating ensures very low weld metal hydrogen levels (&lt;3ml/100g) coupled with excellent current tip transfer. Excellent welder appeal including deslag and low spatter levels.</p> <p>Ideal for overlaying and surfacing components that are subject to metal-metal wear / abrasion.</p>									
<b>Wire Composition(Weight %)</b>										
	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
<b>min.</b>	0.03	1.30	0.30	-	-	5.0	-	0.60	-	-
<b>max.</b>	0.07	1.65	0.65	0.025	0.025	7.0	0.50	0.80	0.30	0.10
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength					N/mm <sup>2</sup>		-		
	Yield Stress/0.2% Proof Stress					N/mm <sup>2</sup>		-		
	Elongation on 5D					%		-		
	Impact Energy CV @					Joules		-		
	Hardness					HRC		57-62		

<b>Wire Dia (mm)</b>		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>min.</b>	-	-	150	160	180	-	-
	<b>max.</b>	-	-	240	260	300	-	-
<b>Volt Range (Volts)</b>	<b>min.</b>	-	-	17	18	20	-	-
	<b>max.</b>	-	-	24	26	29	-	-
<b>Packaging Information</b>								
<b>Kg Per Reel</b>		-	-	16	16	16	-	-
<b>Storage</b>	<p><b>Storage</b> 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%.</p>							
<b>Gases</b>	<p><b>Gas</b> CO<sub>2</sub> or Argon/CO<sub>2</sub> mixture</p> <p><b>Flow Rate</b> 12-16 l/min</p>							

## Current Conditions DC+ and Welding Positions

