



# WB6154 FLUX CORED WELDING WIRE

<b>Classifications</b>	DIN 8555-83 : MSG6-60										
<b>Product Description</b>	Basic, copper coated, hardfacing, tubular, flux cored, welding wire. Fully positional.										
<b>Applications</b>	<p>WB6154 is a basic, medium alloy hardfacing ,flux cored wire with a rapidly solidifying slag.  Easily controllable weld pool, excellent welding properties in all positions. This allows all-position 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 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>	<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%.							
<b>Gases</b>	<b>Gas</b> CO <sub>2</sub> or Argon/CO <sub>2</sub> mixture  <b>Flow Rate</b> 12-16 l/min							

### Current Conditions DC+ and Welding Positions

