



WB6308L-P FLUX CORED WELDING WIRE

Classifications	AWS A5.22-95 : E308LT1-4									
Product Description	Rutile, stainless steel, formed, flux cored, welding wire. Can be used in most positions.									
Applications	<p>WB6308L is suitable for the repair and welding of wrought and cast alloys such as 304, 304L, C12 and 304.S.62 . Suitable for use in corrosive environments up to 400°C.</p> <p>Also suitable for welding type 321 stabilised grade, in addition to types 301, 302 and 303.</p> <p>Typical applications :- food, pressure vessels, valves and general stainless steel engineering.</p> <p>Ferrite in the 5-12 FN range.</p>									
Wire Composition(Weight %)										
min.	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	
max.	0.02	1.0	0.50	-	-	19.0	9.0	-	-	
	0.04	1.5	0.80	0.025	0.025	20.0	11.0	0.30	0.30	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm ²		515 min.		
	Yield Stress/0.2% Proof Stress					N/mm ²		350 min.		
	Elongation on 4D					%		35 min.		
	Impact Energy CV @ -50°C					Joules		27 min.		
	as-welded									

Wire Dia (mm)		0.6mm	0.8mm	0.9mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	80	120	200	-	-
	max.	-	-	160	280	330	-	-
Volt Range (Volts)	min.	-	-	22	22	26	-	-
	max.	-	-	32	34	36	-	-
Packaging Information								
Kg Per Reel		-	-	15	15	15	-	-
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 80% Argon 20% CO ₂ mixture Flow Rate 12-16 l/min							

Current Conditions DC+ and Welding Positions

