



# WB6308L FLUX CORED WELDING WIRE

**Classifications** AWS A5.22-95 : E308LT-1

**Product Description** Rutile, 18/8 Stainless Steel alloyed strip, formed, flux cored welding wire. Can be used in most positions.

**Applications** 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.  
Also suitable for welding type 321 stabilised grade, in addition to types 301, 302 and 303.  
Typical applications :- food, pressure vessels, valves and general stainless steel engineering.

Ferrite in the 5-12 FN range.

**Wire Composition(Weight %)**

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
<b>min.</b>	0.02	1.0	0.50	-	-	19.0	9.0	-	-
<b>max.</b>	0.04	1.5	0.80	0.025	0.025	20.0	11.0	0.30	0.30

<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength	N/mm <sup>2</sup>	515 min.
	Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	350 min.
	Elongation on 4D	%	35 min.
	Impact Energy CV @ -50°C as-welded	Joules	27 min.

Wire Dia (mm)		0.6mm	0.8mm	0.9mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>min.</b>	-	-	80	120	200	-	-
	<b>max.</b>	-	-	160	280	330	-	-
<b>Volt Range (Volts)</b>	<b>min.</b>	-	-	22	22	26	-	-
	<b>max.</b>	-	-	32	34	36	-	-

**Packaging Information**

<b>Kg Per Reel</b>	-	-	12.5	12.5	12.5	-	-
--------------------	---	---	------	------	------	---	---

**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<sub>2</sub> mixture

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

**Current Conditions DC+ and Welding Positions**

