WB6309L FLUX CORED WELDING WIRE

Classifications	AWS A5.22-95 : E309LT0-4
Product Description	Rutile, stainless steel, formed, flux cored, welding wire.
Applications	WB6309L is used mainly for welding the 300 series stainless steels such as 304/304L/321/347/316L/410 and wrought and cast alloys to carbon steels such as 304 clad steels. For cladding it deposits a 308 type deposit on carbon steel and can be followed by 347/308L weld metal. Ferrite 8-20FN range.

Wire Composition(Weight %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
min.	0.02	0.5	0.50	-	-	22.0	12.0	-	-
max.	0.04	2.5	1.00	0.03	0.03	25.0	14.0	0.30	0.30

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm²	515 min.
Yield Stress/0.2% Proof Stress	N/mm²	350 min.
Elongation on 4D	%	30 min.
Impact Energy CV @ 0°C as-welded	Joules	27 min.

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**		-	-	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_2 mixture **Flow Rate** 12-16 l/min

Current Conditions DC+ and Welding Positions