



WB6309LMoP FLUX CORED WELDING WIRE

Classifications	AWS A5.22-95 : E309LMoT1-1/T1-4									
Product Description	All positional, rutile, stainless steel, formed, flux cored, welding wire. WB6309LMoP yields a 316/316L deposit on clad applications.									
Applications	<p>WB6309LMoP is used mainly for welding Molybdenum bearing steels and wrought and cast alloys to Ferritic steels such as 316, 317 and 318 steel.</p> <p>For cladding it deposits a 316-type deposit. It is also used for welding high carbon hardenable steel. 15-30FN range</p>									
Wire Composition(Weight %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	
min.	-	1.0	0.60	-	-	22.0	11.0	2.0	-	
max.	0.04	2.5	1.00	0.010	0.030	25.0	14.0	3.0	0.50	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm ²	>520			
	Yield Stress/0.2% Proof Stress					N/mm ²	>350			
	Elongation on 4D					%	>30			
	Impact Energy CV @ 0°C as-welded					Joules	>27			

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		-	-	15.0	15.0	15.0	-	-
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

