



# WB6316L FLUX CORED WELDING WIRE

<b>Classifications</b>	AWS A5.22-95 : E316LTO-4		BSEN 12073 : T 19 12 3 L R M 3							
<b>Product Description</b>	Rutile, stainless steel, formed, flux cored, welding wire. Can be used in most positions.									
<b>Applications</b>	WB6316L is used mainly for welding and repairing 316L stainless steels and wrought and cast alloys 316, S62, CF3M, CF8M and 316C12 it is also suitable for the mixed welding of 304L, 316L, 321 and 347 stainless steels.  Ferrite in the 3-10FN range. Corrosion resistant up to 400°C.									
<b>Wire Composition(Weight %)</b>	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	
<b>min.</b>	0.02	0.5	0.40	-	-	17.0	11.0	2.0	-	
<b>max.</b>	0.04	2.5	1.00	0.03	0.03	20.0	14.0	3.0	0.30	
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength		N/mm <sup>2</sup>		485 min.					
	Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>		350 min.					
	Elongation on 4D		%		30 min.					
	Impact Energy CV @ -50°C		Joules		27 min.					
	Impact Energy CV @ -196°C as-welded		Joules		27 min.					

<b>Wire Dia (mm)</b>		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	-	-
<b>Packaging Information</b>								
<b>Kg Per Reel</b>		-	-	12.5	12.5	12.5	-	-
<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> 80% Argon 20% CO <sub>2</sub> mixture  <b>Flow Rate</b> 12-16 l/min							

## Current Conditions DC+ and Welding Positions

