



# WB6316LP FLUX CORED WELDING WIRE

|   |   |     |      |       |       |                   |          |     |      |  |
|---|---|-----|------|-------|-------|-------------------|----------|-----|------|--|
| <b>Classifications</b>                              | AWS A5.22-95 : E316LT1-1/T1-4   |     |      |       |       |                   |          |     |      |  |
| <b>Product Description</b>                          | All positional, rutile, stainless steel, formed, flux cored, welding wire.  |     |      |       |       |                   |          |     |      |  |
| <b>Applications</b>                                 | <p>WB6316LP 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.</p> <p>Ferrite in the 6-8FN range.<br/>Corrosion resistant up to 400°C.</p> |     |      |       |       |                   |          |     |      |  |
| <b>Wire Composition(Weight %)</b>                   | C   | Mn  | Si   | S     | P     | Cr                | Ni       | Mo  | Cu   |  |
| <b>min.</b>   | 0.02  | 1.0 | 0.60 | -     | -     | 17.5              | 11.5     | 2.3 | -    |  |
| <b>max.</b>   | 0.04  | 2.0 | 0.90 | 0.025 | 0.030 | 19.5              | 13.5     | 3.5 | 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 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>           |   | -     | -     | 15.0  | 15.0  | 15.0  | -     | -     |
| <b>Storage</b>               | <p><b>Storage</b><br/>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%.</p> |       |       |       |       |       |       |       |
| <b>Gases</b>                 | <p><b>Gas</b><br/>80% Argon 20% CO<sub>2</sub> mixture</p> <p><b>Flow Rate</b><br/>12-16 l/min</p>  |       |       |       |       |       |       |       |

## Current Conditions DC+ and Welding Positions

