



# WB6410NiMo-P FLUX CORED WELDING WIRE

<b>Classifications</b>											
<b>Product Description</b>	Rutile, flux cored, Martensitic stainless steel, tubular, flux cored, welding wire.										
<b>Applications</b>	WB6410NiMo-P deposits a 13Cr 4Ni deposit.										
<b>Wire Composition(Weight %)</b>	C	Mn	Si	S	P	Cr	Ni	Mo			
	<b>min.</b>	0.02	0.5	0.30	-	-	11.0	4.5	0.35		
<b>max.</b>	0.04	1.0	0.80	0.025	0.025	14.5	5.5	0.75			
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength					N/mm <sup>2</sup>	1070	**900			
	Yield Stress/0.2% Proof Stress					N/mm <sup>2</sup>	700	**760			
	Elongation on 5D					%	20	**23			
	Impact Energy CV @ +20°C					Joules	>80	**>47			
	as-welded										
	**PWHT @ 580°C/8 hours										

<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>	-	-	-	120	200	-	-
	<b>max.</b>	-	-	-	280	330	-	-
<b>Volt Range (Volts)</b>	<b>min.</b>	-	-	-	22	26	-	-
	<b>max.</b>	-	-	-	34	36	-	-
<b>Packaging Information</b>								
<b>Kg Per Reel</b>		-	-	-	15.0	15.0	-	-
<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

