

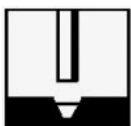


WB6132-R FLUX CORED WELDING WIRE

Classifications	AWS A5.29: E111T1-GM-JH4 EN ISO 18276-A: T69 6 Mn2NiMo P M21 1 H5 AWS A5.36: E111T1-M21A8-K3-H4										
Product Description	Rutile, copper coated, seamless tubular, flux cored, welding wire. Fully positional.										
Applications	WB6132-R is ideal for general fabrication applications and high integrity applications. Seamless tubular technology & copper coating ensures very low weld metal hydrogen levels (<3ml/100g) coupled with excellent current tip transfer. Excellent welder appeal including deslag and low spatter levels. Widely used for the welding of steels with a tensile strength of 810/930 N/mm ² , such as S690QL1, RQT600, HY80, NAXTRA 70 and T1.										
Wire Composition (Wt. %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
min.		0.03	1.40	0.20	-	-	-	1.75	0.10	-	-
max.		0.08	2.00	0.60	0.025	0.025	0.15	2.40	0.30	0.30	0.10
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		*809 **774						
	Yield Stress/0.2% Proof Stress		N/mm ²		*769 **720						
	Elongation on 5D		%		*23 **26						
	Impact Energy CV @ -50°C		Joules		*65 **55						
	*As welded										
	** stress relieved @690°C/1 Hr										

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	150	160	180	-	-
	max.	-	-	240	280	380	-	-
Volt Range (Volts)	min.	-	-	17	18	20	-	-
	max.	-	-	24	26	29	-	-
Packaging Information								
Kg Per Reel		-	-	16	16	16	-	-
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 CO ₂ or Argon/CO ₂ mixture				Flow Rate 15-20 L/min			

Current Conditions DC+ and Welding Positions



Approvals: LR (4Y69S), CE