



WB6316HP FLUX CORED WELDING WIRE

Classifications	AWS A5.22: E316T1-1/4 BS EN ISO 17633-A: T 19 12 3 H P M21 1									
Product Description	Rutile, stainless steel, formed, flux cored, welding wire. Can be used in all positions.									
Applications	WB6316HP is suitable for the repair and welding of 316/316H austenitic stainless steels. Also suitable for welding type 321/321H, 347/347H grades in high service temperatures. WB6316HP has a higher carbon content to provide greater strength at high service temperatures. Typical applications :- Steam piping, superheater headers, furnace parts, Nuclear power stations etc. Ferrite in the 3-8 FN range.									
Wire Composition (Wt. %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu
Min.		0.04	0.5	-	-	-	17.0	11.0	2.00	-
Max.		0.08	2.5	1.0	0.03	0.04	20.0	14.0	3.00	0.75
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		620					
	Yield Stress/0.2% Proof Stress		N/mm ²		460					
	Elongation on 4D		%		41					
	Impact Energy CV @ +20°C		Joules		85					
	As welded									

Wire Dia. (mm)		0.6mm	0.8mm	0.9mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	100	160	250	-	-
	max.	-	-	220	300	380	-	-
Volt Range (Volts)	min.	-	-	17	18	22	-	-
	max.	-	-	28	30	32	-	-
Packaging Information								
Kg Per Reel		-	-	15	15	15	-	-
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 15-20 L/min							

Current Conditions DC+ and Welding Positions

