



WB6134-MC METAL CORED WELDING WIRE

Classifications	AWS A5.28: E120C-GH4 EN ISO 18276-A: T89 5 ZMn2NiCrMo M M21 1 H5										
Product Description	High Strength, metal cored, seamless copper coated, tubular welding wire.										
Applications	WB6134-MC is ideal for general fabrication applications and high integrity applications. 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 T2, Weldox 900 and steels with a tensile strength of 940-1180 N/mm ² .										
Wire Composition (Wt. %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
	min.	0.06	1.50	0.30	-	-	0.20	2.4	0.40	-	-
	max.	0.12	2.00	0.60	0.025	0.025	0.60	2.7	0.65	0.30	0.10
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		1280						
	Yield Stress/0.2% Proof Stress		N/mm ²		930						
	Elongation on 5D		%		17						
	Impact Energy CV @ -40°C		Joules		58 Ave.						

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	300	380	-	-
Volt Range (Volts)	min.	-	-	17	18	20	-	-
	max.	-	-	24	27	30	-	-
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 Argon/CO ₂ mixture Flow Rate 15-20 L/min							

Current Conditions DC+ and Welding Positions

