



## WB6131 FLUX CORED WELDING WIRE

<b>Classifications</b>	<b>AWS A5.36: E91-T5-K4</b>									
<b>Product Description</b>	Basic, copper coated, tubular, flux cored, welding wire. Fully positional.									
<b>Applications</b>	<p>WB6131 is ideal for general fabrication applications and high integrity applications.</p> <p>Tubular technology &amp; copper coating ensures very low weld metal hydrogen levels (&lt;3ml/100g) coupled with excellent current tip transfer. Excellent welder appeal including deslag and low spatter levels.</p> <p>Widely used for the welding of steels with a tensile strength of 750/850 N/mm<sup>2</sup>, such as RQT600, HY80, NAXTRA 70 and T1.</p>									
<b>Wire Composition (Wt. %)</b>	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
<b>min.</b>	0.04	1.10	0.30	-	-	-	1.10	0.30	-	-
<b>max.</b>	0.08	1.75	0.60	0.025	0.025	0.10	1.25	0.60	0.30	0.10
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength		N/mm <sup>2</sup>		760-900					
	Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>		690 min.					
	Elongation on 5D		%		15 min.					
	Impact Energy CV @ -51°C		Joules		27 min.					
	As welded									

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

### Current Conditions DC+ and Welding Positions

