



WB6309L FLUX CORED WELDING WIRE

Classifications	AWS A5.22: E309LT0-1/4 BS EN ISO 17633-A: T 23 12 L R M21 3									
Product Description	Rutile, stainless steel, formed, flux cored, welding wire. Specially designed for use in the downhand position.									
Applications	<p>WB6309L is used mainly for welding the 300 series stainless steels such as 304/304L/321/347/316L/410 and wrought and cast alloys to carbon steels such as 304 clad steels.</p> <p>For cladding it deposits a 308-type deposit on carbon steel and can be followed by 347/308L weld metal.</p> <p>Ferrite 8-20FN range.</p>									
Wire Composition (Wt. %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu
min.		0.02	0.5	0.50	-	-	22.0	12.0	-	-
max.		0.04	2.5	1.00	0.03	0.03	25.0	14.0	0.30	0.30
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		515 min.					
	Yield Stress/0.2% Proof Stress		N/mm ²		350 min.					
	Elongation on 4D		%		30 min.					
	Impact Energy CV @ 0°C		Joules		27 min.					
	As welded									

Wire Dia. (mm)		0.6mm	0.8mm	0.9mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	100	120	200	-	-
	max.	-	-	220	300	380	-	-
Volt Range (Volts)	min.	-	-	17	18	22	-	-
	max.	-	-	28	30	32	-	-
Packaging Information								
Kg Per Reel		-	-	12.5	12.5	12.5	-	-
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

