

WB6308H FLUX CORED WELDING WIRE

Classifications	AWS A5.22 : E308HT0-4									
Product Description	Rutile, stainless steel, formed, flux cored, welding wire. Can be used in most positions.									
Applications	WB6308H is suitable for the repair and welding of wrought and cast alloys such as 304, 304L, C12 and 304.S.62 . Suitable for use in corrosive environments up to 400°C. Also suitable for welding type 321 stabilised grade, in addition to types 301, 302 and 303. Typical applications: - food, pressure vessels, valves and general stainless steel engineering. Ferrite in the 5-12 FN range.									
Wire Composition(Weight %)										
	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	
min.	0.04	0.5	0.50	-	-	18.0	9.0	-	-	
max.	0.08	2.0	1.00	0.025	0.03	21.0	11.0	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				%		35 min.			
	Impact Energy CV @ -50°C as-welded				Joules		27 min.			

Wire Dia (mm)		0.6mm	0.8mm	0.9mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	80	120	200	-	-
	max.	-	-	160	280	330	-	-
Volt Range (Volts)	min.	-	-	22	22	26	-	-
	max.	-	-	32	34	36	-	-
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 12-16 l/min							

Current Conditions DC+ and Welding Positions

