



# WB6308LP FLUX CORED WELDING WIRE

<b>Classifications</b>	<b>AWS A5.22:</b> E308LT1-1/4 <b>BS EN ISO 17633-A:</b> T 19 9 L P M1/C 1									
<b>Product Description</b>	Rutile, stainless steel, formed, flux cored, welding wire. Can be used in all positions.									
<b>Applications</b>	<p>WB6308L-P 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.</p> <p>Also suitable for welding type 321 stabilised grade, in addition to types 301, 302 and 303.</p> <p>Typical applications - food, pressure vessels, valves and general stainless-steel engineering.</p> <p>Ferrite in the 5-12 FN range.</p>									
<b>Wire Composition (Wt. %)</b>		C	Mn	Si	S	P	Cr	Ni	Mo	Cu
<b>min.</b>		0.02	1.0	0.50	-	-	19.0	9.0	-	-
<b>max.</b>		0.04	1.5	0.80	0.025	0.025	20.0	11.0	0.30	0.30
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength		N/mm <sup>2</sup>			515 min.				
	Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>			350 min.				
	Elongation on 4D		%			35 min.				
	Impact Energy CV @ -50°C		Joules			27 min.				
	As welded									

<b>Wire Dia. (mm)</b>		0.6mm	0.8mm	0.9mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>min.</b>	-	-	100	120	200	-	-
	<b>max.</b>	-	-	220	300	380	-	-
<b>Volt Range (Volts)</b>	<b>min.</b>	-	-	17	18	22	-	-
	<b>max.</b>	-	-	28	30	32	-	-
<b>Packaging Information</b>								
<b>Kg Per Reel</b>		-	-	15	15	15	-	-
<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> 80% Argon 20% CO <sub>2</sub> mixture  <b>Flow Rate</b> 15-20 L/min							

### Current Conditions DC+ and Welding Positions

