

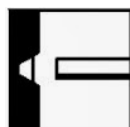


WB6132 FLUX CORED WELDING WIRE

Classifications	AWS A5.29: E110T5-K4M-H4 BS EN ISO 18276-A: T69 6 Mn2NiCrMo B M21 3 H5 AWS A5.36: E110T5-M21A8-K4-H4										
Product Description	Basic, copper coated, seamless tubular, flux cored, welding wire. Fully positional.										
Applications	WB6132 is ideal for general fabrication applications and high integrity applications. Seamless 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 steels with a tensile strength of 750/850 N/mm ² , such as RQT600, RQT701, HY80, NAXTRA 70 and T1.										
Wire Composition (Wt. %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
	min.	0.06	1.50	0.30	-	-	0.30	2.0	0.40	-	-
	max.	0.09	2.00	0.60	0.025	0.025	0.60	2.5	0.70	0.30	0.10
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		*760-900		**740-840				
	Yield Stress/0.2% Proof Stress		N/mm ²		*690 min.		**670 min.				
	Elongation on 5D		%		*15 min.		**16 min.				
	Impact Energy CV @ -51°C		Joules		*27 min.		**47J Avg.(-60°C)				
	*as welded										
	** stress relieved @690°C/1 Hr										

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	280	380	-	-
Volt Range (Volts)	min.	-	-	17	18	20	-	-
	max.	-	-	24	26	29	-	-
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 CO ₂ or Argon/CO ₂ mixture				Flow Rate 15-20 L/min			

Current Conditions DC+ and Welding Positions



Approvals: LR (5Y69S), CE