



WB6316L FLUX CORED WELDING WIRE

Classifications	AWS A5.22: E316LT0-1/4		BS EN ISO 17633-A: T 19 12 3 L R M 3						
Product Description	Rutile, stainless steel, formed, flux cored, welding wire. Specially designed for use in the downhand position.								
Applications	WB6316L is used mainly for welding and repairing 316L stainless steels and wrought and cast alloys 316, S62, CF3M, CF8M and 316C12 it is also suitable for the mixed welding of 304L, 316L, 321 and 347 stainless steels. Ferrite in the 3-10FN range. Corrosion resistant up to 400°C.								
Wire Composition (Wt. %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
min.	0.02	0.5	0.40	-	-	17.0	11.0	2.0	-
max.	0.04	2.5	1.00	0.03	0.03	20.0	14.0	3.0	0.30
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		485 min.				
	Yield Stress/0.2% Proof Stress		N/mm ²		350 min.				
	Elongation on 4D		%		30 min.				
	Impact Energy CV @ -50°C		Joules		27 min.				
	Impact Energy CV @ -196°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	150	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

