



# WB6130 FLUX CORED WELDING WIRE

<b>Classifications</b>	<b>AWS A5.20:</b> E70T-5M/C-JH4 <b>BS EN ISO 17632-A:</b> T46 4 B M21 3 H5									
<b>Product Description</b>	Basic, copper coated, seamless tubular, flux cored, welding wire. Fully positional.									
<b>Applications</b>	<p>WB6130 is ideal for general fabrication applications and high integrity applications such as power generation and low temperature service.</p> <p>Seamless tubular technology &amp; copper coating ensures very low weld metal hydrogen levels (&lt;3ml/100g) coupled with excellent current tip transfer. Excellent welder appeal including deslag and low spatter levels.</p> <p>Recommend for the welding of mild/medium tensile steels up to grade 50D, having a tensile strength of ~500 N/mm<sup>2</sup>, Lloyds A and E ship steel, BS1449 plate and sheet.</p>									
<b>Wire Composition (Wt. %)</b>	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
<b>min.</b>	0.04	1.10	0.40	-	-	-	-	-	-	-
<b>max.</b>	0.08	1.75	0.70	0.025	0.025	0.10	0.50	0.10	0.30	0.10
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength                      N/mm <sup>2</sup> 530-680 Yield Stress/0.2% Proof Stress              N/mm <sup>2</sup> 460 min. Elongation on 5D                                    %                              20 min. Impact Energy CV @ -40°C                    Joules                      47 min. As welded									

<b>Wire dia. (mm)</b>		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>min.</b>	-	-	150	160	180	450	-
	<b>max.</b>	-	-	240	260	380	600	-
<b>Volt Range (Volts)</b>	<b>min.</b>	-	-	17	18	20	35	-
	<b>max.</b>	-	-	24	26	29	38	-
<b>Packaging Information</b>								
<b>Kg Per Reel</b>		-	-	16	16	16	16/25	-
<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> CO <sub>2</sub> or Argon/CO <sub>2</sub> mixture			<b>Flow Rate</b> 15-20 L/min				

### Current Conditions DC+ and Welding Positions



**Approvals:** LR (4YS), CE