



# WB6410NiMo METAL CORED WELDING WIRE

<b>Classifications</b>	<b>AWS A5.22:</b> E410NiMoT0-1/4 <b>BS EN ISO 17633:</b> T 13 4 M M 3										
<b>Product Description</b>	Metal cored, Martensitic stainless steel, tubular, flux cored, welding wire.										
<b>Applications</b>	WB6410NiMo deposits a 13Cr 4Ni deposit.										
<b>Wire Composition (Wt. %)</b>	C	Mn	Si	S	P	Cr	Ni	Mo			
	min.	0.02	0.5	0.50	-	-	11.0	4.5	0.35		
	max.	0.04	1.0	0.80	0.025	0.025	14.5	5.5	0.75		
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength					N/mm <sup>2</sup>	1070 **900				
	Yield Stress/0.2% Proof Stress					N/mm <sup>2</sup>	700 **760				
	Elongation on 5D					%	20 **23				
	Impact Energy CV @ +20°C					Joules	>80 **>47				
	As welded										
	**PWHT @ 580°C/8 hours										

<b>Wire Dia. (mm)</b>		0.6mm	0.8mm	0.9mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	min.	-	-	-	150	180	-	-
	max.	-	-	-	280	380	-	-
<b>Volt Range (Volts)</b>	min.	-	-	-	18	20	-	-
	max.	-	-	-	28	30	-	-
<b>Packaging Information</b>								
<b>Kg Per Reel</b>		-	-	-	15.0	15.0	-	-
<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

