



WB6310 FLUX CORED WELDING WIRE

Classifications	AWS A5.22: E310T0-1/4 BS EN ISO 17633-A: T 25 20 R C1/M21 3									
Product Description	Rutile, stainless steel, formed, flux cored, welding wire.									
Applications	<p>Used mainly for welding and repairing 310 type stainless steels and dissimilar combinations of high temperature steels.</p> <p>The weld deposit can be post-weld-heat-treated without loss of properties. Can be used for welding the following materials:- BS310S24, 310S31 & 310C24, ASTM310, 310S & CK20, DIN 1.4841, 1.4845 & 1.4840.</p>									
Wire Composition (Wt. %)		C	Mn	Si	S	P	Mo	Cr	Ni	Cu
min.		0.06	1.0	0.50	-	-	0.20	23.0	18.0	-
max.		0.20	5.0	1.00	0.020	0.025	0.30	27.0	22.0	0.20
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		650					
	Yield Stress/0.2% Proof Stress		N/mm ²		375					
	Elongation on 5D		%		27					
	Impact Energy CV @ +20°C		Joules		75					
	As welded									

Wire Dia. (mm)		0.6mm	0.8mm	0.9mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	80	120	200	-	-
	max.	-	-	200	280	360	-	-
Volt Range (Volts)	min.	-	-	15	15	26	-	-
	max.	-	-	26	29	32	-	-
Packaging Information								
Kg Per Reel		-	-	15.0	15.0	15.0	-	-
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

