



WB6410NiMoP FLUX CORED WELDING WIRE

Classifications	AWS A5.22: E410NiMoT1-1/4 BS EN ISO 17633-A: T 13 4 R C/M 1									
Product Description	Rutile, flux cored, Martensitic stainless steel, tubular, flux cored, welding wire.									
Applications	WB6410NiMo-P deposits a 13Cr 4Ni deposit.									
Wire Composition (Wt. %)	C	Mn	Si	S	P	Cr	Ni	Mo		
	min. max.	0.02 0.04	0.5 1.0	0.30 0.80	- 0.025	- 0.025	11.0 14.5	4.5 5.5	0.35 0.75	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength				N/mm ²		1070 **900			
	Yield Stress/0.2% Proof Stress				N/mm ²		700 **760			
	Elongation on 5D				%		20 **23			
	Impact Energy CV @ +20°C as-welded				Joules		>80 **>47			
	**PWHT @ 580°C/8 hours									

Wire Dia. (mm)		0.6mm	0.8mm	0.9mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	-	150	180	-	-
	max.	-	-	-	280	380	-	-
Volt Range (Volts)	min.	-	-	-	18	20	-	-
	max.	-	-	-	28	30	-	-
Packaging Information								
Kg Per Reel		-	-	-	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 or 100% CO ₂ Flow Rate 15-20 L/min							

Current Conditions DC+ and Welding Positions

