



WB6154-MC FLUX CORED WELDING WIRE

Classifications	DIN 8555-83: MSG6-60 + MF10-GF-65-GR BS EN ISO 14700: T Fe8										
Product Description	Metal-cored, copper coated, hardfacing, tubular, flux cored, welding wire.										
Applications	<p>WB6154-MC is a metal-cored, medium alloy hardfacing cored wire. Easily controllable weld pool, excellent welding properties with no need to de-slag. This allows welding with high currents, consequently yielding a high deposition rate. Tubular technology & copper coating ensures very low weld metal hydrogen levels (<3ml/100g) coupled with excellent current tip transfer. Excellent welder appeal including de-slag and low spatter levels.</p> <p>Ideal for overlaying and surfacing components that are subject to metal-metal wear / abrasion.</p>										
Wire Composition (Wt. %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
	min.	0.03	1.30	0.30	-	-	5.0	-	0.60	-	-
	max.	0.07	1.65	0.65	0.025	0.025	7.0	0.50	0.80	0.30	0.10
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		-						
	Yield Stress/0.2% Proof Stress		N/mm ²		-						
	Elongation on 5D		%		-						
	Impact Energy CV @		Joules		-						
	Hardness		HRC		42-52						

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	150	160	180	-	-
	max.	-	-	240	260	300	-	-
Volt Range (Volts)	min.	-	-	17	18	20	-	-
	max.	-	-	24	26	29	-	-
Packaging Information								
Kg Per Reel		-	-	16	16	16	-	-
Storage	<p>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%.</p>							
Gases	<p>Gas CO₂ or Argon/CO₂ mixture</p> <p>Flow Rate 15-20 L/min</p>							

Current Conditions DC+ and Welding Positions

