

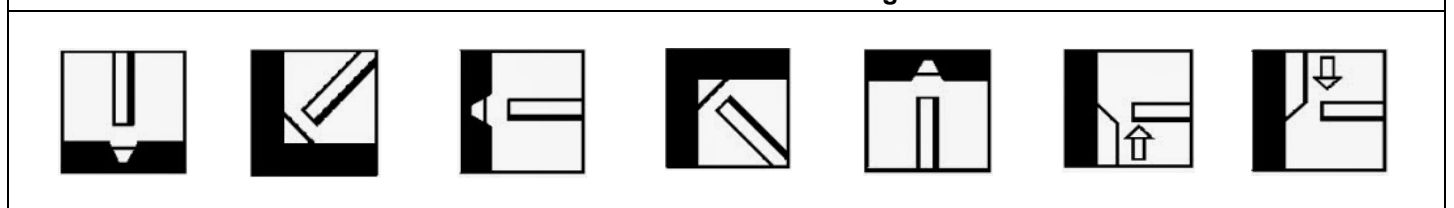


WB6114 FLUX CORED WELDING WIRE

Classifications	BS EN ISO 17632-A: T 46 4 P M21 1 H5 / T46 2 P C1 1 H5 AWS A5.20: E71T1-M/T9M/T-12M JDH4 / E71T1C/T-9C/T-12C DH4 AWS A5.36: E71T1-M21A4-CS1-DH4 / E71T1-C1A2-C S1-DH4										
Product Description	Rutile, copper coated, tubular, flux cored, welding wire. Fully positional.										
Applications	<p>WB6114 is ideal for general fabrication applications. Excellent deposition rates due to metal powder technology. Excellent weldability in wide gaps, poor fit ups etc.</p> <p>Seamless tubular technology & copper coating ensures very low weld metal hydrogen levels (<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/mm², Lloyds A and E ship steel, BS1449 plate and sheet.</p>										
Wire Composition (Wt. %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
min.		0.04	1.10	0.30	-	-	-	-	-	-	-
max.		0.08	1.65	0.65	0.025	0.025	0.10	0.50	0.10	0.30	0.10
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		530-680						
	Yield Stress/0.2% Proof Stress		N/mm ²		460 min.						
	Elongation on 5D		%		20 min.						
	Impact Energy CV @ -40°C		Joules		47 min.						
	As welded										

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	280	380	-	-
Volt Range (Volts)	min.	-	-	17	18	20	-	-
	max.	-	-	24	26	29	-	-
Packaging Information								
Kg Per Reel		-	-	16/5	16/5	16/5	-	-
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 CO ₂ or Argon/CO ₂ mixture				Flow Rate 15-20 L/min			

Current Conditions DC+ and Welding Positions



Approvals: LR (4Y40S), CWB, CE