



WB6111E-NG FLUX CORED WELDING WIRE

Classifications/Approvals	AWS A5.20: E71T-8 AWS A5.36/A5.36M: E71T8-A2									
Product Description	Self-Shielded, cored welding wire. Fully positional.									
Applications	WB6111E-NG is ideal for general fabrication applications. Excellent welder appeal including deslag and low spatter levels. Recommend for the welding of mild/medium tensile steels up to grade 50D, having a tensile strength of ~500 N/mm ² , ship grade steel, BS1449 plate and sheet.									
Wire Composition (Wt. %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
min.	0.10	0.40	0.20	-	-	-	-	-	-	1.45
max.	0.30	0.80	0.50	0.025	0.025	0.10	0.50	0.1	0.30	1.75
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength				N/mm ²		>540			
	Yield Stress/0.2% Proof Stress				N/mm ²		>480			
	Elongation on 5D				%		>22			
	Impact Energy CV @ -20°C				Joules		>47			
	As welded									

Wire Dia. (mm)		0.6mm	0.8mm	0.9mm	1.2mm	1.4mm	1.6mm	3.2mm
Current Range (Amps)	min.	-	-	80	150	200	200	-
	max.	-	-	100	170	300	340	-
Volt Range (Volts)	min.	-	-	17	20	22	22	-
	max.	-	-	20	22	30	32	-
Packaging Information								
Kg Per Reel		-	-	16.0	16.0	16.0	16.0	-
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 Not required			Flow Rate Not Required				
	Polarity For best results use DCEN							

Current Conditions DC+ and Welding Positions

