WB6308HP FLUX CORED WELDING WIRE

Classifications	**AWS A5.22:** E308HT1-1/4 **BS EN ISO 17633-A:** T 19 9 H P M21 1
Product Description	Rutile, stainless steel, formed, flux cored, welding wire. Can be used in all positions.
Applications	WB6308HP is suitable for the repair and welding of wrought and cast alloys such as 301, 302, 304 and 304H. WB6308HP has a higher carbon content to provide greater strength at high service temperatures. Typical applications - food, pressure vessels, values and general stainless-steel engineering. Ferrite typically 4-8 FN.

Wire Composition (Wt. %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
min.	0.04	0.5	-	-	-	18.0	9.0	-	-
max.	0.08	2.5	0.80	0.03	0.04	21.0	11.0	0.75	0.75

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm²	550 min.	*595
Yield Stress/0.2% Proof Stress	N/mm²	350 min.	*390
Elongation on 4D	%	25 min.	*40
Impact Energy CV @ -50°C As welded	Joules	>27 min.	*85

*Typical

Wire Dia. (mm)		0.6mm	0.8mm	0.9mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	**min.**	-	-	100	160	250	-	-
	max.	-	-	220	300	380	-	-
Volt Range (Volts)	**min.**	-	-	17	18	22	-	-
	max.	-	-	28	30	32	-	-
Packaging Information **Kg Per Reel**		-	-	15	15	15	-	-

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