

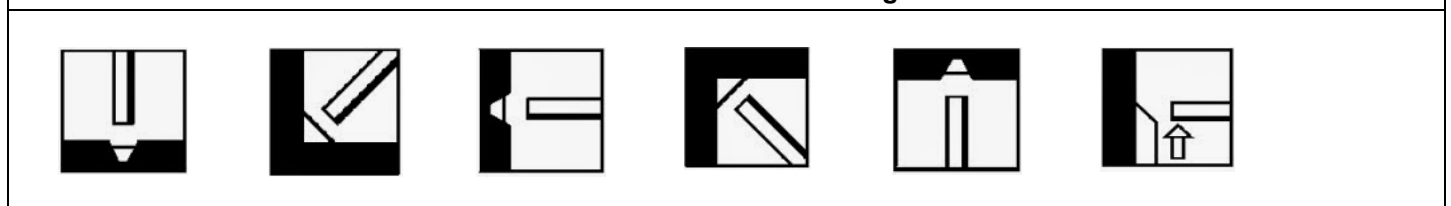


WB6130 FLUX CORED WELDING WIRE

Classifications	AWS A5.20: E71T5-M/C-JH4 BS EN ISO 17632-A: T42 4 B M21 1 H5 AWS A5.36: E71T5-M21-A4-CS1-H4										
Product Description	Basic, copper coated, seamless tubular, flux cored, welding wire. Fully positional.										
Applications	<p>WB6130 is ideal for general fabrication applications and high integrity applications such as power generation and low temperature service.</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	0.40	-	-	-	-	-	-	-
max.		0.08	1.75	0.70	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		510-660						
	Yield Stress/0.2% Proof Stress		N/mm ²		410 min.						
	Elongation on 5D		%		22 min.						
	Impact Energy CV @ -50°C		Joules		27 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	450	-
	max.	-	-	240	260	380	600	-
Volt Range (Volts)	min.	-	-	17	18	20	35	-
	max.	-	-	24	26	29	38	-
Packaging Information								
Kg Per Reel		-	-	16	16	16	16/25	-
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 (4YS), CE