# WB6309LMoP FLUX CORED WELDING WIRE

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| **Classifications** | **AWS A5.22:** E309LMoT1-1/4 **BS EN ISO 17633-A**: T 23 12 2 L P M 1 |
| **Product Description** | All positional, rutile, stainless steel, formed, flux cored, welding wire. WB6309LMoP yields a 316/316L deposit on clad applications. |
| **Applications** | WB6309LMoP is used mainly for welding Molybdenum bearing steels and wrought and cast alloys to Austenitic stainless steels such as 316, 317 and 318 steel.<br><br>For cladding it deposits a 316-type deposit. It is also used for welding high carbon hardenable steel. 15-30FN range |

**Wire Composition (Wt. %)**

| | C | Mn | Si | S | P | Cr | Ni | Mo | Cu | |
|---|---|---|---|---|---|---|---|---|---|---|
| **min.** | - | 1.0 | 0.60 | - | - | 22.0 | 11.0 | 2.0 | - | |
| **max.** | 0.04 | 2.5 | 1.00 | 0.010 | 0.030 | 25.0 | 14.0 | 3.0 | 0.50 | |

**Typical All-Weld Metal Mechanical Properties**

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|---|---|---|
| Ultimate Tensile Strength | N/mm² | >520 |
| Yield Stress/0.2% Proof Stress | N/mm² | >350 |
| Elongation on 4D | % | >30 |
| Impact Energy CV @ 0°C | Joules | >27 |

As welded

| **Wire Dia. (mm)** | | 0.6mm | 0.8mm | 0.9mm | 1.2mm | 1.6mm | 2.4mm | 3.2mm |
|---|---|---|---|---|---|---|---|---|
| **Current Range (Amps)** | **min.** | - | - | 100 | 140 | 200 | - | - |
| | **max.** | - | - | 200 | 280 | 380 | - | - |
| **Volt Range (Volts)** | **min.** | - | - | 17 | 18 | 22 | - | - |
| | **max.** | - | - | 28 | 30 | 32 | - | - |
| **Packaging Information**<br>**Kg Per Reel** | | - | - | 15.0 | 15.0 | 15.0 | - | - |

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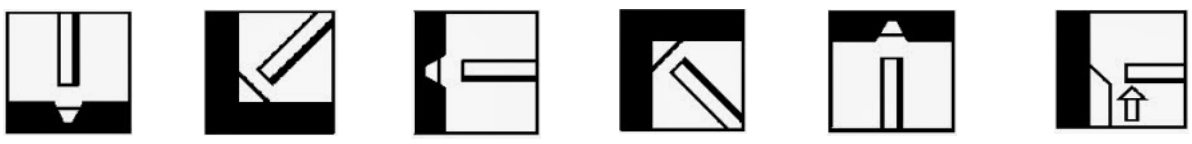
| **Storage** | **Storage**<br>It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%. |
| **Gases** | **Gas**<br>80% Argon 20% $CO_2$ mixture<br><br>**Flow Rate**<br>15-20 L/min |

**Current Conditions DC+ and Welding Positions**



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