



WB6132-MC METAL CORED WELDING WIRE

Classifications	AWS A5.28: E110C-K4H4 EN ISO 18276-A: T69 6 Mn2NiCrMo M M21 1 H5 AWS A5.36: E110T15-M21A8-K4-H4										
Product Description	High Strength, seamless metal cored, copper coated, tubular, flux cored welding wire.										
Applications	WB6132-MC is ideal for general fabrication applications and high integrity applications. Fully positional in short circuit transfer but optimised for downhand welding. Seamless tubular technology & copper coating ensures very low weld metal hydrogen levels (<3ml/100g) coupled with excellent current tip transfer. Excellent welder appeal including low volume of silicate islands and minimal spatter levels. Widely used for the welding of T1, Weldox 700 and steels with a tensile strength of 750-800 N/mm ² .										
Wire Composition (Wt. %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
	min.	0.05	1.10	0.30	-	-	-	2.0	0.30	-	-
	max.	0.10	1.75	0.60	0.025	0.025	0.2	2.4	0.60	0.30	0.10
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		*760-900		**750-870				
	Yield Stress/0.2% Proof Stress		N/mm ²		*690 min.		**710 min.				
	Elongation on 5D		%		*15 min.		**17 min.				
	Impact Energy CV @ -51°C		Joules		27 min.		47J Avg. (-60°C)				
	*As welded										
	**Stress Relieved @690°C/1Hr										

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	16	16	-	-
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 Argon/CO ₂ mixture				Flow Rate 15-20 L/min			

Current Conditions DC+ and Welding Positions

