# WB6308L FLUX CORED WELDING WIRE

| Classifications | **AWS A5.22:** E308LT0-1/4 | **BS EN ISO 17633-A:** T 19 9 L R M21 3 |
|---|---|---|
| **Product Description** | Rutile, stainless steel, formed, flux cored, welding wire. This wire is specially designed for use in the downhand position. ||
| **Applications** | WB6308L is suitable for the repair and welding of wrought and cast alloys such as 304, 304L, C12 and 304.S.62. Suitable for use in corrosive environments up to 400°C.<br>Also suitable for welding type 321 stabilised grade, in addition to types 301, 302 and 303.<br>Typical applications: - food processing plant, pressure vessels and general stainless-steel fabrications.<br>Ferrite in the 5-12 FN range. ||

| Wire Composition (Wt. %) | | C | Mn | Si | S | P | Cr | Ni | Mo | Cu | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | min. | 0.02 | 0.5 | 0.50 | - | - | 18.0 | 9.0 | - | - | |
| | max. | 0.04 | 2.0 | 1.00 | 0.025 | 0.03 | 21.0 | 11.0 | 0.30 | 0.30 | |

| Typical All-Weld Metal Mechanical Properties | | | |
|---|---|---|---|
| Ultimate Tensile Strength | N/mm² | 515 min. |
| Yield Stress/0.2% Proof Stress | N/mm² | 350 min. |
| Elongation on 4D | % | 35 min. |
| Impact Energy CV @ -50°C | Joules | 27 min. |
| As welded | | |

| Wire dia. (mm) | | 0.6mm | 0.8mm | 0.9mm | 1.2mm | 1.6mm | 2.4mm | 3.2mm |
|---|---|---|---|---|---|---|---|---|
| **Current Range (Amps)** | min. | - | - | 80 | 100 | 200 | - | - |
| | max. | - | - | 220 | 280 | 330 | - | - |
| **Volt Range (Volts)** | min. | - | - | 17 | 18 | 22 | - | - |
| | max. | - | - | 26 | 28 | 30 | - | - |
| **Packaging Information Kg Per Reel** | | - | - | 12.5 | 12.5 | 12.5 | - | - |

| 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