MAGMA North America

WB6132

FLUX CORED WELDING WIRE

Classifications	**AWS A5.36:** E110T5-M21A8-K4-H4 **BS EN ISO 18276-A:** T69 6 Mn2NiCrMo B M21 3 H5
Product Description	Basic, copper coated, seamless tubular, flux cored, welding wire. Fully positional.
Applications	WB 6132 is ideal for general fabrication applications and high integrity applications. 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. Widely used for the welding of steels with a tensile strength of 750/850 N/mm^2, such as RQT600, RQT701, HY80, NAXTRA 70 and T1.

Composition (Wt. %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
Min.	0.06	1.50	0.30	-	-	0.30	2.0	0.40	-	-
Max.	0.09	2.00	0.60	0.025	0.025	0.60	2.5	0.70	0.30	0.10

Typical All-Weld Metal Mechanical Properties				
	Ultimate Tensile Strength	N/mm^2	*760-900	**740-840
	Yield Stress/0.2% Proof Stress	N/mm^2	*690 min.	**670 min.
	Elongation on 5D	%	*15 min.	**16 min.
	Impact Energy CV @-51°C	Joules	*27 min.	**47J Avg. (-60°C)
	*as welded			
	**stress relieved @690°C/1Hr			

Wire Diameter (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		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%.						

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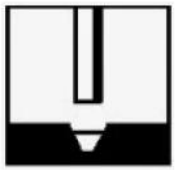
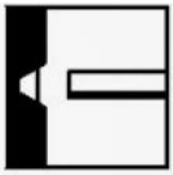
Gases	Gas	Flow Rate
	CO_2 or Argon/ CO_2 mixture	15-20 L/min

Current Conditions DC+ and Welding Positions





Approvals: LR 5Y69S, TÜV, CE

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