



# WB6114

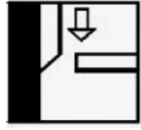
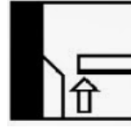
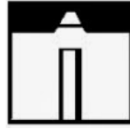
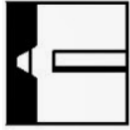


## FLUX CORED WELDING WIRE

<b>Classifications</b>	<b>AWS A5.36:</b> E71T1-M21-AP4-CS2-H4 <b>BS EN ISO 17632-A:</b> T46 4 P M21 1 H5									
<b>Product Description</b>	Rutile, copper coated, tubular, flux cored, welding wire. Fully positional.									
<b>Applications</b>	WB6114 is ideal for general fabrication applications. Excellent deposition rates due to metal powder technology. Excellent weldability in wide gaps, poor fit ups etc.  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.  Recommend for the welding of mild/medium tensile steels up to grade 50D, having a tensile strength of ~500 N/mm <sup>2</sup> , Lloyds A and E ship steel, BS1449 plate and sheet.									
<b>Composition (Wt. %)</b>	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
<b>Min.</b>	0.04	1.10	0.30	-	-	-	-	-	-	-
<b>Max.</b>	0.08	1.65	0.65	0.025	0.025	0.10	0.50	0.10	0.30	0.10
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength		N/mm <sup>2</sup>		530-680					
	Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>		460 min.					
	Elongation on 5D		%		20 min.					
	Impact Energy CV @-40°C as welded		Joules		47 min.					

<b>Wire Diameter (mm)</b>	0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>Min.</b>	-	-	150	160	180	-
	<b>Max.</b>	-	-	240	280	380	-
<b>Volt Range (Volts)</b>	<b>Min.</b>	-	-	17	18	20	-
	<b>Max.</b>	-	-	24	26	29	-
<b>Packaging Information KG per Reel</b>	-	-	16/5	16/5	16/5	-	-
<b>Storage</b>	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%.						
<b>Gases</b>	<b>Gas</b>	<b>Flow Rate</b>					
	CO <sub>2</sub> or Argon/ CO <sub>2</sub> mixture	15-20 L/min					

**Current Conditions DC+ and Welding Positions**



**Approvals:** LR 4Y40S, DNV-GL, CWB, TÜV, ABS, CE