WB6114

FLUX CORED WELDING WIRE

Classifications	**AWS A5.36:** E71T1-M21-AP4-CS2-H4 **BS EN ISO 17632-A:** T46 4 P M21 1 H5
Product Description	Rutile, copper coated, tubular, flux cored, welding wire. Fully positional.
Applications	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/mm², Lloyds A and E ship steel, BS1449 plate and sheet.

Composition (Wt. %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
Min.	0.04	1.10	0.30	-	-	-	-	-	-	-
Max.	0.08	1.65	0.65	0.025	0.025	0.10	0.50	0.10	0.30	0.10

Typical All-Weld Metal Mechanical Properties			
	Ultimate Tensile Strength	N/mm^2	530-680
	Yield Stress/0.2% Proof Stress	N/mm^2	460 min.
	Elongation on 5D	%	20 min.
	Impact Energy CV @-40°C as welded	Joules	47 min.

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		-	-	16/5	16/5	16/5	-	-

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

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Current Conditions DC+ and Welding Positions

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

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