



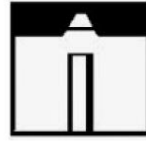
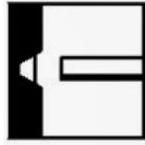
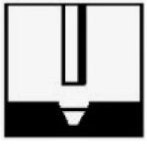
WB 61320-MC

METAL CORED WELDING WIRE

Classifications	AWS A5.36: E110T15-M21A8-K4-H4 EN ISO 18276-A: T69 6 Mn2NiCrMo M M 1 H5									
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 optimized for downhand welding. Seamless tubular technology and 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 T1, Weldox 700 and steels with a tensile strength of 750-800 N/mm ² .									
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 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%.							
Gases	Gas		Flow Rate					
	Argon/CO ₂ mixture		15-20 L/min					

Current Conditions DC+ and Welding Positions



Approvals: DNV-GL, TUV, CE