

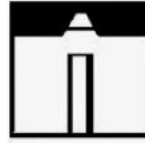
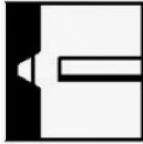
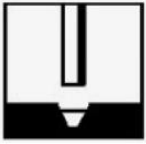
WB6132-R

FLUX CORED WELDING WIRE

Classifications	AWS A5.36: E111T1-M21A8-K3-H4 EN ISO 18276-A: T69 6 Mn2NiMo P M21 1 H5																									
Product Description	Rutile, copper coated, seamless tubular, flux cored welding wire. Fully positional.																									
Applications	WB6132-R is ideal for general fabrication applications and high integrity applications. 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 steels with a tensile strength of 810/930 N/mm ² , such as S690QL1, RQT600, HY80, NAXTRA 70 and T1.																									
Composition (Wt. %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al																
Min	0.03	1.40	0.20	-	-	-	1.75	0.10	-	-																
Max	0.08	2.00	0.60	0.025	0.025	0.15	2.40	0.30	0.30	0.10																
Typical All-Weld Metal Mechanical Properties	<table border="0"> <tr> <td>Ultimate Tensile Strength</td> <td>N/mm²</td> <td>*809</td> <td>**774</td> </tr> <tr> <td>Yield Stress/0.2% Proof Stress</td> <td>N/mm²</td> <td>*769</td> <td>**720</td> </tr> <tr> <td>Elongation on 5D</td> <td>%</td> <td>*23</td> <td>**26</td> </tr> <tr> <td>Impact Energy CV @-50°C</td> <td>Joules</td> <td>65</td> <td>**55</td> </tr> </table> <p>*As welded **Stress Relieved @690°C/1Hr</p>										Ultimate Tensile Strength	N/mm ²	*809	**774	Yield Stress/0.2% Proof Stress	N/mm ²	*769	**720	Elongation on 5D	%	*23	**26	Impact Energy CV @-50°C	Joules	65	**55
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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						
	CO ₂ or Argon/CO ₂ mixture	15-20 L/min						

Current Conditions DC+ and Welding Positions



Approvals: LR 4Y69S, DNV-GL IVY69MS (H5), ABS, TUV, CE