

WB6111E FLUX CORED WELDING WIRE

Classifications/Approvals	AWS A5.20-95 : E71-T1-M BS EN ISO 17632 : 2015 : T46 3 PC1 H5										
Product Description	Rutile, "strip technology" cored welding wire. Fully positional.										
Applications	<p>WB6111E is ideal for general fabrication applications. Excellent welder appeal including deslag and low spatter levels.</p> <p>Recommend for the welding of mild/medium tensile steels up to grade 50D, having a tensile strength of ~500 N/mm², Lloyds A and D ship steel, BS1449 plate and sheet.</p> <p>Typical weld metal hydrogen levels of <3ml/100g.</p>										
Wire Composition (Weight %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
min.		0.040	1.10	0.35	-	-	-	-	-	-	-
max.		0.08	1.65	0.75	0.025	0.025	0.10	0.50	0.1	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			%		22 min.			
			Impact Energy CV @ -30°C as welded			Joules		47 min.			
Wire Dia (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm			
Current Range (Amps)	min.	-	-	150	160	180	-	-			
	max.	-	-	240	260	300	-	-			
Volt Range (Volts)	min.	-	-	17	18	20	-	-			
	max.	-	-	24	26	29	-	-			
Packaging Information											
Kg Per Reel		-	-	16	16	16	-	-			
Storage	<p>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%.</p>										
Gases	<p>Gas CO₂ or Argon/CO₂ mixture</p> <p>Flow Rate 12-16 l/min</p>										
Current Conditions DC+ and Welding Positions											
											