



WB6121 FLUX CORED WELDING WIRE

Classifications	AWS A5.36 : E81-T1-M21A8-Ni1 H4 BS EN ISO17632-A:T5061NiPM1H5 AWS A5.01-09 : CLASS T3 LRS ABS									
Product Description	Rutile, copper coated, tubular, flux cored, welding wire. Fully positional.									
Applications	WB6121 is a rutile, flux cored wire with a rapidly solidifying slag. Easily controllable weld pool, excellent welding properties in all positions. This allows all-position welding with high currents, consequently yielding a high deposition rate. 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. Ideal for high integrity offshore applications and general fabrication where service requirements require impact properties down to -60°C. Designed for use in all positions and is particularly easy to use vertically up and overhead.									
Wire Composition(Weight %)										
	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
min.	0.03	1.00	0.30	-	-	-	0.70	-	-	-
max.	0.08	1.40	0.65	0.025	0.025	0.10	1.00	0.15	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 @ -60°C Joules 47 min. as-welded							Typical 687 631 26 >60		

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	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%.Product can be left in production area for max 72 hours.							
Gases	Gas CO ₂ or Argon/CO ₂ mixture Flow Rate 12-16 l/min							

Current Conditions DC+ and Welding Positions

