



WB6603ER FLUX CORED WELDING WIRE

Classifications	AWS A5.29-95 : E91T1-B3M										
Product Description	Rutile, seamless, copper coated, flux cored, welding wire. Fully positional.										
Applications	WB6603ER is a rutile, precision layer wound, seamless, copper coated, flux cored wire with a rapidly solidifying slag. Easily controllable weld pool, excellent welding properties, very high deposition rate. Typical weld metal hydrogen levels <5ml/100g. Suitable for welding 2%Cr ,1%Mo and 0.5%Cr 0.25%V creep-resisting steels in high integrity applications such as power generation and low temperature service. Scaling and creep resistance to 600°C.										
Wire Composition(Weight %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al	
min.	0.05	0.5	0.10	-	-	2.0	-	0.90	-	-	-
max.	0.10	1.2	0.60	0.025	0.025	2.5	0.20	1.20	0.30	0.10	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm ²	*790				
	Yield Stress/0.2% Proof Stress					N/mm ²	*698				
	Elongation on 4D					%	*22				
	Impact Energy CV @ +20°C					Joules	*45, 55, 52				
	*stress relieved @690°C/1Hr										

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%.							
Gases	Gas CO ₂ or Argon/CO ₂ mixture							
	Flow Rate 12-16 l/min							

Current Conditions DC+ and Welding Positions

