



WB6615ER FLUX CORED WELDING WIRE

Classifications	AWS A5.29-95 : E81T1-B2M									
Product Description	Rutile, formed, flux cored, welding wire. Fully positional.									
Applications	WB6615ER is suitable for welding 1.25%Cr 0.5%Mo creep-resisting steels. Typical grades:- BS1501:Part 2 620, BS1503 Grade 620/621, BS1504 Grade 620 and BS3100 Grade B2, ASTM A335 Grades P11 & P12, A182 F11, ASTM A199, A200 & A213. Scaling and creep resistance to 550°C.									
All-Weld Metal Composition (Weight %)	C	Mn	Si	S	P	Mo	Cr	V	Cu	
min.	0.08	0.70	0.20	-	-	0.45	1.00	-	-	
max.	0.12	0.90	0.80	0.020	0.025	0.65	1.30	0.03	0.03	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm ²	700			
	Yield Stress/0.2% Proof Stress					N/mm ²	634			
	Elongation on 4D					%	21			
	Impact Energy CV @ +20°C stress relieved @690°C/1Hr					Joules	39, 42, 46			

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

