



WB6P91 FLUX CORED WELDING WIRE

Classifications	AWS A5.29: E91T1-B9MH4 BS EN ISO 17634-B: T69T1-1M-9C1MV-H5										
Product Description	Rutile, seamless, copper coated, flux cored, welding wire. Fully positional.										
Applications	WB6P91 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 <3ml/100g. Suitable for welding modified 9%Cr/Mo 0.2%V creep resisting steels. The addition of small amounts of Vanadium and Nitrogen improve long-term creep properties. Used mainly by the power engineering industry for headers, steam piping and turbine rotors. Typical material grades:- A213-T91, DIN 1.4903, A335 P91, A387 Gr. 91, A182 F91, A217 C12A. Scaling and creep resistance to 600°C. Sb <0.005, typical 0.004										
Wire Composition(Wt. %)		C	Mn	Si	S	P	Cr	Ni	Mo	Nb	V
min.		0.08	0.60	0.20	-	-	8.0	0.30	0.90	0.03	0.18
max.		0.12	1.20	0.40	0.015	0.020	9.5	0.60	1.10	0.07	0.25
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		*793						
	Yield Stress/0.2% Proof Stress		N/mm ²		*687						
	Elongation on 4D		%		*22						
	Impact Energy CV @ +20°C		Joules		*>22						
	*Stress relieved @760°C/2Hr										

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.	-	-	200	300	380	-	-
Volt Range (Volts)	min.	-	-	17	18	20	-	-
	max.	-	-	22	28	30	-	-
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 15-20 L/min							

Current Conditions DC+ and Welding Positions

