



WB6121-Mo FLUX CORED WELDING WIRE

Classifications	AWS A5.29: E101T1-K2M-JH4 BS EN ISO 18276-A: T62 4 Mn1.5Ni P M21 1 H5										
Product Description	Tubular, Copper coated, flux cored, welding wire. Fully positional.										
Applications	<p>WB6121-Mo is a rutile, 1.5Ni-0.1Mo, flux cored wire. Easily controllable weld pool, excellent welding properties in all positions. This allows all-position welding with high currents, consequently yielding a high deposition rate.</p> <p>Unique manufacturing technology ensures very low weld metal hydrogen levels (<3ml/100g). Excellent welder appeal including deslag and low spatter levels. Ideal for high integrity offshore/defence applications where service requirements require impact properties down to -50°C. Meets the requirements and is approved for HY100 material, Def Stan 02-769, 02-770 part 2 standards.</p>										
Wire Composition (Wt. %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
min.		0.030	1.50	0.20	-	-	-	1.50	0.10	-	-
max.		0.070	1.75	0.50	0.020	0.020	0.15	1.80	0.20	0.30	0.10
All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		MPa		>700						
	Yield Stress/0.2% Proof Stress		MPa		>620						
	Elongation on 5D		%		>18						
	Impact Energy CV @ -50°C		Joules		>80						
	As welded										

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	-	160	180	-	-
	max.	-	-	-	280	380	-	-
Volt Range (Volts)	min.	-	-	-	18	20	-	-
	max.	-	-	-	26	29	-	-
Packaging Information								
Kg Per Reel		-	-	-	5.0/16.0	5.0/16.0	-	-
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

