



## WB6615ER FLUX CORED WELDING WIRE

<b>Classifications</b>	AWS A5.36: E81T1-B2M									
<b>Product Description</b>	Rutile, formed, flux cored, welding wire. Fully positional.									
<b>Applications</b>	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.									
<b>All-Weld Metal Composition (Weight %)</b>	C	Mn	Si	S	P	Mo	Cr	V	Cu	
<b>min.</b>	0.08	0.70	0.20	-	-	0.45	1.00	-	-	
<b>max.</b>	0.12	0.90	0.80	0.020	0.025	0.65	1.30	0.03	0.03	
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength					N/mm <sup>2</sup>	700			
	Yield Stress/0.2% Proof Stress					N/mm <sup>2</sup>	634			
	Elongation on 4D					%	21			
	Impact Energy CV @ +20°C stress relieved @690°C/1Hr					Joules	39, 42, 46			

<b>Wire Dia. (mm)</b>		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>min.</b>	-	-	150	160	180	-	-
	<b>max.</b>	-	-	240	280	380	-	-
<b>Volt Range (Volts)</b>	<b>min.</b>	-	-	17	18	20	-	-
	<b>max.</b>	-	-	24	26	29	-	-
<b>Packaging Information</b>								
<b>Kg Per Reel</b>		-	-	16	16	16	-	-
<b>Storage</b>	<b>Storage</b> 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%.							
<b>Gases</b>	<b>Gas</b> CO <sub>2</sub> or Argon/CO <sub>2</sub> mixture				<b>Flow Rate</b> 15-20 L/min			

### Current Conditions DC+ and Welding Positions

