



## WB6602ER FLUX CORED WELDING WIRE

<b>Classifications</b>	<b>AWS A5.29:</b> E81T1-B2M-H4 <b>BS EN ISO 17634-A:</b> T CrMo1 P M21 1 H5										
<b>Product Description</b>	Rutile, seamless, copper coated, flux cored, welding wire. Fully positional.										
<b>Applications</b>	WB6602ER 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 1 ¼ Cr, ½ 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 500°C.										
<b>Wire Composition (Wt. %)</b>		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
<b>min.</b>		0.04	0.5	0.20	-	-	1.00	-	0.45	-	-
<b>max.</b>		0.10	1.2	0.60	0.025	0.025	1.25	0.20	0.65	0.30	0.10
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength		N/mm <sup>2</sup>		*655						
	Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>		*574						
	Elongation on 4D		%		*23						
	Impact Energy CV @ +20°C		Joules		*56, 59, 76						
	*Stress relieved @690°C/6Hr										

<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

