



6121 FLUX CORED WELDING WIRE

Classifications	AWS A5.29: E81T1-Ni1M/C-JH4 BS EN ISO 17632-A: T50 6 1Ni P M21 1 H5 AWS A5.36: E81T1-M21A8-Ni1 H4										
Product Description	Rutile, copper coated, seamless tubular, flux cored, welding wire. Fully positional.										
Applications	6121 is a rutile, flux cored wire with a rapidly solidifying slag. Easily controllable weld pool, excellent welding properties in all positions. This allows all-position welding with high currents, consequently yielding a high deposition rate. Seamless tubular technology & copper coating ensures very low weld metal hydrogen levels (<3ml/100g) coupled with excellent current tip transfer. Excellent welder appeal including deslag and low spatter levels. Ideal for high integrity offshore applications, weathering steel and general fabrication where service requirements require impact properties down to -60°C. Designed for use in all positions and is particularly easy to use vertically up and overhead. Lot class T3 available on request, as per AWS A5.01:2019.										
Wire Composition (Wt. %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
min.		0.03	1.00	0.30	-	-	-	0.70	-	-	-
max.		0.08	1.40	0.65	0.025	0.025	0.10	1.00	0.15	0.30	0.10
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength N/mm ² 510-690 Yield Stress/0.2% Proof Stress N/mm ² 500 min. Elongation on 5D % 22 min. Impact Energy CV @ -60°C Joules 47 min. As welded								Typical 630 520 27 >70		

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	280	380	-	-
Volt Range (Volts)	min.	-	-	17	18	20	-	-
	max.	-	-	24	26	29	-	-
Packaging Information								
Kg Per Reel		-	-	16/5	16/5	16/5	-	-
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%. Product can be left in production area for max 72 hours.							
Gases	Gas CO ₂ or Argon/CO ₂ mixture				Flow Rate 15-20 L/min			

Current Conditions DC+ and Welding Positions

