



# WB6603ER FLUX CORED WELDING WIRE

<b>Classifications</b>	<b>AWS A5.29:</b> E91T1-B3M-H4 <b>BS EN ISO 17634-A:</b> T CrMo2 P M21 1 H5 <b>AWS A5.29:</b> E91T1-B3C-H4										
<b>Product Description</b>	Rutile, seamless, copper coated, flux cored, welding wire. Fully positional.										
<b>Applications</b>	WB6603ER 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 <5ml/100g. Suitable for welding 2%Cr, 1%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 600°C.										
<b>Wire Composition (Wt. %)</b>		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
	<b>min.</b>	0.05	0.5	0.10	-	-	2.0	-	0.90	-	-
	<b>max.</b>	0.10	1.2	0.60	0.025	0.025	2.5	0.20	1.20	0.30	0.10
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength					N/mm <sup>2</sup>	*790				
	Yield Stress/0.2% Proof Stress					N/mm <sup>2</sup>	*698				
	Elongation on 4D					%	*22				
	Impact Energy CV @ +20°C					Joules	*45, 55, 52				
	*Stress relieved @690°C/1Hr										

<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

