



WB6121-Mo FLUX CORED WELDING WIRE

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|---|---|--------------------------------|------|------|-------|--------|---------|------|------|------|------|
| Classifications | AWS A5.29: E101T1-K2M-H4 BS EN ISO 17632-A: T62 4 1.5Ni P M21 1 H5 AWS A5.36: E101T1-M21A4-K2-H4 | | | | | | | | | | |
| Product Description | Tubular, Copper coated, flux cored, welding wire. Fully positional. | | | | | | | | | | |
| Applications | 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. 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. | | | | | | | | | | |
| 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 |
| Typical All-Weld Metal Mechanical Properties | | Ultimate Tensile Strength | | | | MPa | 700-760 | | | | |
| | | Yield Stress/0.2% Proof Stress | | | | MPa | 620 | | | | |
| | | Elongation on 5D | | | | % | >18 | | | | |
| | | Impact Energy CV @ -50°C | | | | Joules | >80 | | | | |
| | | As welded | | | | | | | | | |

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|------------------------------|---|-------|-------|-------|----------|----------|-------|-------|
| 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

