



WB6121-Cu FLUX CORED WELDING WIRE

Classifications	AWS A5.29: E81T1-WGM-H4 BS EN ISO 17632-A: T46 4 Z P M21 1 H5 AWS A5.36: E81T1-M21A4-G-H4									
Product Description	Rutile, seamless, copper coated, flux cored, welding wire. Fully positional.									
Applications	WB6121-Cu 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. 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 weathering steels and general fabrication. Designed for use in all positions and is particularly easy to use vertically up and overhead.									
Wire Composition (Wt. %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
min.	0.03	1.10	0.20	-	-	-	0.90	-	0.25	-
max.	0.07	1.40	0.60	0.025	0.025	0.10	1.40	0.15	0.55	0.10
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		590-680					
	Yield Stress/0.2% Proof Stress		N/mm ²		470 min.					
	Elongation on 5D		%		>22					
	Impact Energy CV @ -40°C		Joules		>47					
	As welded									

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	16	16	-	-
Storage	Storage It is recommended that the WB range of consumables is stored in a dry heated store at a minimum temperature of 16°C, and a maximum relative humidity of 60%. To avoid damage to the coatings no more than 9 cartons should be stacked on top of another.							
Gases	Gas CO ₂ or Argon/CO ₂ mixture Flow Rate 15-20 L/min							

Current Conditions DC+ and Welding Positions

