



WB6123 FLUX CORED WELDING WIRE

Classifications	AWS A5.29: E81T1-Ni2M/C-JH4 AWS A5.36: E81T1-M21A8-Ni2-H4		BS EN ISO 17632-A: T50 6 2Ni P M21 1 H5 LR (5Y46S)							
Product Description	Rutile, copper coated, seamless tubular, flux cored, welding wire for CO ₂ or mixed gases. Fully positional.									
Applications	WB6123 is a rutile, 2.5% Ni, 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 offshore applications and general fabrication where service requirements require impact properties down to -60°C with excellent CTOD values. 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.	0.035	1.00	0.30	-	-	-	2.00	-	-	-
max.	0.070	1.50	0.65	0.020	0.025	0.10	2.75	0.10	0.30	0.10
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		540-690					
	Yield Stress/0.2% Proof Stress		N/mm ²		460 min.					
	Elongation on 5D		%		22 min.					
	Impact Energy CV @ -60°C		Joules		≥ 47 min.					
	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 wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%. It is recommended that WB wires should be used within a 12-hour period of being exposed to the atmosphere, in conditions of high humidity.							
Gases	Gas CO ₂ or Argon/CO ₂ mixture Flow Rate 15-20 L/min							

Current Conditions DC+ and Welding Positions

