



## WB6602 FLUX CORED WELDING WIRE

<b>Classifications</b>	<b>AWS A5.29:</b> E80T5-GM-H4 <b>BS EN ISO 17634-A:</b> T46 CrMo1 B M21 4 H5 <b>AWS A5.36:</b> E80T5-G-M21-H4										
<b>Product Description</b>	Basic, 0.5% Mo, copper coated, tubular, flux cored, welding wire. Fully positional.										
<b>Applications</b>	WB6602 is a basic, copper coated, precision layer wound, tubular flux cored wire with a rapidly solidifying slag. Easily controllable weld pool, excellent welding properties, very high deposition rate. Typical weld metal hydrogen levels <3ml/100g.  Suitable for welding 0.5%Mo steels in high integrity applications.										
<b>Wire Composition (Wt. %)</b>		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
	<b>min.</b>	0.05	1.0	0.30	-	-	0.80	-	0.40	-	-
	<b>max.</b>	0.10	1.5	0.60	0.025	0.025	1.20	0.20	0.60	0.30	0.10
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength					N/mm <sup>2</sup>	*560-690				
	Yield Stress/0.2% Proof Stress					N/mm <sup>2</sup>	*>470				
	Elongation on 5D					%	*>19				
	Impact Energy CV @ +20°C					Joules	*>47 Ave.				
	*stress relieved @620°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

