

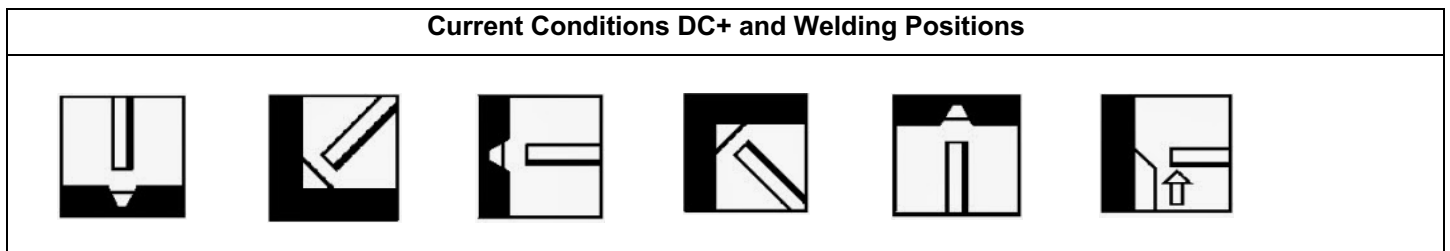


WB6121SR FLUX CORED WELDING WIRE

Classifications	AWS A5.29: E81T1-Ni1M/C-JH4 BS EN ISO 17632-A: T50 6 1Ni P M21 1 H5 AWS A5.36: E81T1-M21AP8-Ni1-H4										
Product Description	Rutile, copper coated, tubular, stress relievable, flux cored wire. Fully positional.										
Applications	WB6121SR is a rutile, flux cored wire with a rapidly solidifying slag. Easily controllable weld pool with excellent welding properties, allowing fully positional welding with high currents high deposition rates. WB6121SR can be used in the as welded or stress relieved condition. Seamless tubular technology & copper coating 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. 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	1.25	0.20	-	-	-	0.70	-	-	-
max.		0.07	1.60	0.60	0.025	0.025	0.10	1.00	0.15	0.30	0.10
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		**638		***673				
	Yield Stress/0.2% Proof Stress		N/mm ²		**560		***637				
	Elongation on 5D		%		**24		***25				
	Impact Energy CV @ -40°C		Joules		**85		***61				
	Impact Energy CV @ -60°C		Joules		**52						
	**PWHT @620°C x 2Hr										
	*** 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		-	-	5/16	5/16	5/16	-	-
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%.							
Gases	Gas CO ₂ or Argon/CO ₂ mixture				Flow Rate 15-20 L/min			

Current Conditions DC+ and Welding Positions



Approvals: LR (5Y46S/4Y46srS), CWB, CE