



WB6603ER

FLUX CORED WELDING WIRE

Classifications	AWS A5.36: E91T1-B3M H4										
Product Description	Rutile, copper coated, seamless, flux cored, welding wire. Fully positional.										
Applications	WB 6603ER is a rutile, precision layer wound, seamless, copper coated, flux cored wire with a rapidly solidifying slag. Easily controllable weld pool, excellent welding properties, very high deposition rate. Typical weld metal hydrogen levels <5ml/100g. Suitable for welding 2%Cr, 1%Mo and 0.5%Cr 0.25%V creep-resisting steels in high integrity applications such as power generation and low temperature service. Scaling and creep resistance to 600°C.										
Composition (Wt. %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al	
	Min.	0.05	0.50	0.10	-	-	2.00	-	0.90	-	-
	Max.	0.10	1.20	0.60	0.025	0.025	2.50	0.20	1.20	0.30	0.10
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		*790						
	Yield Stress/0.2% Proof Stress		N/mm ²		*698						
	Elongation on 5D		%		*22						
	Impact Energy CV @+20°C		Joules		*45, 55, 52						
	**stress relieved @690°C/1Hr										

Wire Diameter (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	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			Flow Rate				
	CO ₂ or Argon/ CO ₂ mixture			15-20 L/min				

Current Conditions DC+ and Welding Positions

