



WB6121



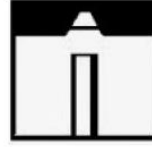
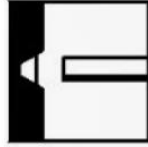
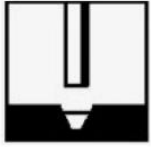
FLUX CORED WELDING WIRE

Classifications	AWS A5.36: E81T1-M21A8-Ni1 H4 BS EN ISO 17632-A: T50 6 1Ni P M 1 H5									
Product Description	Rutile, copper coated, seamless tubular, flux cored, welding wire. Fully positional.									
Applications	<p>WB6121 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.</p> <p>Seamless tubular technology & copper coating ensures very low weld metal hydrogen levels (<3ml/100g) coupled with excellent current tip transfer. Excellent welder appeal including deslag and low spatter levels.</p> <p>Ideal for high integrity offshore applications, weathering steel 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.</p> <p>Lot class T3 available on request, as per AWS A5.01:2019.</p>									
Composition (Wt. %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
Min.	0.03	1.00	0.30	-	-	-	0.70	-	-	-
Max.	0.08	1.40	0.65	0.025	0.025	0.10	1.00	0.15	0.30	0.10
Typical All-Weld Metal Mechanical Properties	<u>Typical</u>									
	Ultimate Tensile Strength					N/mm ²	560-720		687	
	Yield Stress/0.2% Proof Stress					N/mm ²	500 min.		631	
	Elongation on 5D					%	18 min.		27	
	Impact Energy CV @-60°C as welded					Joules	47 min.		>70	

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	-	-	16/5	16/5	16/5	-	-
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



Approvals: LR 5Y46S, TÜV, ABS, DNV-GL, CWB, CE