



# WB6121-Mo

## FLUX CORED WELDING WIRE

<b>Classifications</b>	<b>AWS A5.36:</b> E101T1-M21A4-K2-H4 <b>BS EN ISO 17632-A:</b> T62 4 1.5Ni P M21 1 H5										
<b>Product Description</b>	Tubular, copper coated, flux cored, welding wire. Fully positional.										
<b>Applications</b>	<p>WB6121-Mo is a rutile, 1.5Ni-0.1Mo, flux cored wire. 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>Unique manufacturing technology ensures very low weld metal hydrogen levels (&lt;3ml/100g). Excellent welder appeal including deslag and low spatter levels. Ideal for high integrity offshore/defence applications where service requirements require impact properties down to -50°C. Meets the requirements and is approved for HY100 material, Def Stan 02-769, 02-770 part 2 standards.</p>										
<b>Composition (Wt. %)</b>	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al	
<b>Min.</b>	0.03	1.50	0.20	-	-	-	1.50	0.10	-	-	
<b>Max.</b>	0.07	1.75	0.50	0.020	0.020	0.15	1.80	0.20	0.30	0.10	
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength					MPa	700-760				
	Yield Stress/0.2% Proof Stress					MPa	620				
	Elongation on 5D					%	>18				
	Impact Energy CV @-50°C as welded					Joules	>80				

<b>Wire Diameter (mm)</b>		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>Min.</b>	-	-	-	160	180	-	-
	<b>Max.</b>	-	-	-	280	380	-	-
<b>Volt Range (Volts)</b>	<b>Min.</b>	-	-	-	18	20	-	-
	<b>Max.</b>	-	-	-	26	29	-	-
<b>Packaging Information</b>								
<b>KG per Reel</b>		-	-	-	5.0/16.0	5.0/16.0	-	-
<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>				<b>Flow Rate</b>			
	CO <sub>2</sub> or Argon/ CO <sub>2</sub> mixture				15-20 L/min			

**Current Conditions DC+ and Welding Positions**

