



# WB6000 M.I.G. WELDING WIRE

**Classifications** AWS A5.18-05 : ER70S-6 BS EN ISO 14341-A:2008 : G46 4MG3 Si1

**Product Description** Copper Coated, Controlled Carbon-Manganese-Silicon steel solid MIG wire.

**Applications** Suitable for welding and repairing most C-Mn steels.

**Wire Composition (Weight %)**

	C	Mn	Si	S	P	Ni	Cr	Mo	Cu (total)
<b>min.</b>	0.06	1.30	0.75	-	-	-	-	-	-
<b>max.</b>	0.12	1.60	1.00	0.025	0.025	0.15	0.15	0.15	0.30

**Typical All-Weld Metal Mechanical Properties**

Ultimate Tensile Strength	N/mm <sup>2</sup>	530 min.
Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	460 min.
Elongation on 5D	%	22 min.
Impact Energy CV @ -20°C	Joules	>80
Impact Energy CV @ -29°C	Joules	>60
Impact Energy CV @ -30°C	Joules	>55
Impact Energy CV @ -40°C as-welded	Joules	>30

Wire Dia (mm)		0.6mm	0.8/0.9mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>min.</b>		-	80	120	160	180	-	-
<b>Current Range (Amps)</b>	<b>max.</b>	-	180	240	260	300	-	-
<b>min.</b>		-	17	17	18	20	-	-
<b>Volt Range (Volts)</b>	<b>max.</b>	-	20	22	26	29	-	-

**Packaging Information**

<b>Kg Per Std Reel</b>	-	0.7/5/20	0.7/5/20	20	20	-	-
<b>Kg Per Bulk Reel</b>		200	250	250	250		

**Storage** **Storage**  
It is recommended that the WB ranges 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 MIG</b> CO <sub>2</sub> and Argon/CO <sub>2</sub> mixture	<b>Gas TIG</b> Argon
	<b>Flow Rate</b> 12-16 l/min	<b>Flow Rate</b> 8-12 l/min

**Current Conditions DC+ and Welding Positions**

