



# WB6010 M.I.G. WELDING WIRE

<b>Classifications</b>	AWS A5.18-95 : ER70S.2									
<b>Product Description</b>	Copper coated Carbon-Manganese steel solid MIG wire.									
<b>Applications</b>	Triple deoxidised MIG wire suitable for welding and repairing C-Mn steels.									
<b>Wire Composition(Weight %)</b>	C	Mn	Si	S	P	Ni	Cr	Mo	Al	
	min. 0.08 max. 0.12	1.20 1.50	0.60 0.85	- 0.030	- 0.030	- 0.15	- 0.15	- 0.15	0.20 0.40	
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength				N/mm <sup>2</sup>		510-630			
	Yield Stress/0.2% Proof Stress				N/mm <sup>2</sup>		430 min.			
	Elongation on 5D				%		22 min.			
	Impact Energy CV @ 0°C as-welded				Joules		47min.			

<b>Wire Dia (mm)</b>		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	min.	-	80	120	160	180	-	-
	max.	-	180	240	260	300	-	-
<b>Volt Range (Volts)</b>	min.	-	17	17	18	20	-	-
	max.	-	20	22	26	29	-	-
<b>Packaging Information</b>								
<b>Kg Per Reel</b>		-	15	15	15	15	-	-
<b>Storage</b>	<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> CO <sub>2</sub> and Argon/CO <sub>2</sub> mixture  <b>Flow Rate</b> 12-16 l/min							

## Current Conditions DC+ and Welding Positions

