



# WB6012 M.I.G. WELDING WIRE

**Classifications** AWS A5.28-79 : ER80S-G

**Product Description** Copper coated, Cor-Ten type solid MIG wire.

**Applications** WB6012 is suitable for welding Cor-Ten type weathering steels.

Typical grades:- Cor-ten A, B, Patinax and BS4360-50A

**Wire Composition(Weight %)**

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
<b>min.</b>	0.08	1.20	0.70	-	-	-	0.60	-	0.25
<b>max.</b>	0.11	1.50	0.90	0.025	0.025	0.15	0.90	0.15	0.45

**Typical All-Weld Metal Mechanical Properties**

Ultimate Tensile Strength	N/mm <sup>2</sup>	550-660
Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	430 min.
Elongation on 5D	%	22 min.
Impact Energy CV @ -20°C as-welded	Joules	47min.

Wire Dia (mm)		0.6mm	0.8mm	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 Reel</b>	-	15	15	15	15	-	-
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**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**  
CO<sub>2</sub> and Argon/CO<sub>2</sub> mixture

**Flow Rate**  
12-16 l/min

**Current Conditions DC+ and Welding Positions**

