



WB6013 M.I.G. WELDING WIRE

Classifications AWS A5.28 : ER80S-Ni1 BS EN ISO 14341-A - 2008 : G 46 6 M G3 Ni1

Product Description Copper coated 1% Nickel solid MIG wire.

Applications
 WB6013 is a solid MIG wire for the welding of low temperature steels such as A333 Grade 6 or equivalent, with excellent notch toughness values down to -60°C. The Nickel content of WB6013 is such that compliance with N.A.C.E. specification is ensured. The balanced Manganese and Silicon ensures optimum deoxidisation and weld fluidity. Can also be used for the welding of weathering steels, such as Cor-Ten A and Cor-Ten B.

Wire Composition(Weight %)	C	Mn	Si	S	P	Ni	Cr	Mo	Cu
min.	0.06	1.00	0.40	-	-	0.80	-	-	0.20
max.	0.12	1.25	0.80	0.020	0.020	1.10	0.15	0.15	0.35

Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength	N/mm ²	590 min.
	Yield Stress/0.2% Proof Stress	N/mm ²	470 min.
	Elongation on 5D	%	20 min.
	Impact Energy CV @ -60°C as-welded	Joules	35min.

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

Packaging Information

Kg Per Reel	-	0.7/15	0.7/15	15	15	-	-
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Storage
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
 CO₂ and Argon/CO₂ mixture

Flow Rate
 12-16 l/min

Current Conditions DC+ and Welding Positions

