



WB6040 M.I.G. WELDING WIRE

Classifications	AWS A5.28 : ER80S-Ni2 BSEN440-95 : G506MG2Ni2									
Product Description	Copper coated 2% Nickel solid MIG wire.									
Applications	WB6040 is a solid MIG wire for the welding of low temperature steels down to -50°C. The balanced Manganese and Silicon ensures optimum deoxidisation and weld fluidity.									
Wire Composition(Weight %)	C	Mn	Si	S	P	Ni	Cr	Mo		
min.	0.05	0.90	0.40	-	-	2.20	-	-		
max.	0.10	1.25	0.80	0.025	0.025	2.50	0.15	0.015		
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength				N/mm ²		560-720			
	Yield Stress/0.2% Proof Stress				N/mm ²		500 min.			
	Elongation on 5D				%		18 min.			
	Impact Energy CV @ -60°C as-welded				Joules		47min.			

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		-	15	15	15	15	-	-
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 CO ₂ and Argon/CO ₂ mixture Flow Rate 12-16 l/min							

Current Conditions DC+ and Welding Positions

