



WB6041 M.I.G. WELDING WIRE

Classifications

AWS A5.28-79 : ER80S-D2 BSEN440-95 : G463MG2Mo
BS 2901:Pt 1 - Type A31

Product Description

Copper coated Carbon-Manganese-Molybdenum solid MIG wire.

Applications

High strength MIG wire for welding high strength steels with good sub zero notch toughness in the PWHT condition.

Wire Composition(Weight %)

	C	Mn	Si	S	P	Ni	Cr	Mo	Cu (total)
min.	0.07	0.80	0.50	-	-	-	-	0.40	-
max.	0.12	1.40	0.90	0.025	0.025	0.15	0.15	0.60	0.30

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm ²	530-680
Yield Stress/0.2% Proof Stress	N/mm ²	460 min.
Elongation on 5D	%	20 min.
Impact Energy CV @ -30°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	-	-
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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

