



WB6042 M.I.G. WELDING WIRE

Classifications AWS A5.28-79 : ER80S-B2

Product Description Copper coated 1.25% Chromium, 0.5% Molybdenum solid MIG wire.

WB6042 is suitable for welding 1.25%Cr, 0.5%Mo creep-resisting steels.

Applications

The balanced Manganese and Silicon ensures optimum deoxidisation and weld fluidity.

Typical grades:- BS1501:Part 2 620, BS1503 Grade 620/621, BS1504 Grade 620 and BS3100 Grade B2, ASTM A335 Grades P11 & P12, A182 F11, ASTM A199, A200 & A213.

Scaling and creep resistance to 550°C.

Wire Composition(Weight %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
min.	0.08	0.80	0.40	-	-	1.10	-	0.45	-
max.	0.12	1.20	0.80	0.025	0.025	1.50	0.03	0.65	0.10

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm ²	550-650
Yield Stress/0.2% Proof Stress	N/mm ²	470 min.
Elongation on 5D	%	22 min.
Impact Energy CV @ +20°C	Joules	47min.
Stress relieved @ 690°C / 1Hr		

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	-	0.7/5/15	0.7/5/15	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 MIG**
CO₂ and Argon/CO₂ mixture

Gas TIG
Argon

Flow Rate
12-16 l/min

Flow Rate
8-12 l/min

Current Conditions DC+ and Welding Positions

