



WB6043 M.I.G. WELDING WIRE

Classifications	~AWS A5.28 : ER90S-B3 BS EN ISO 21952-A : GCrMo2Si										
Product Description	Copper coated 2% Chromium, 1% Molybdenum solid MIG wire.										
Applications	<p>WB6043 is suitable for welding 2%Cr 1%Mo creep-resisting steels.</p> <p>The balanced Manganese and Silicon ensures optimum deoxidisation and weld fluidity.</p> <p>Typical material grades :- BS1501 Part 2 Grade 622, ASTM A387 D, BS1503 Grade 622, BS1504 Grade 622, BS3100 Grade B3, ASTM A217 WC9, BS1503 Grade 660, BS1504 Grade 660, BS3100 Grade B7.</p> <p>Scaling and creep resistance to 600°C.</p> <p>WB6043 conforms to National Power specification requirements.</p>										
Wire Composition(Weight %)											
	C	Mn	Si	S	P	Cr	Ni	Mo	V	As	
min.	0.08	0.90	0.50	-	-	2.20	-	0.90	-	-	
max.	0.12	1.20	0.80	0.015	0.015	2.60	0.15	1.10	0.02	0.035	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm ²	620 min.				
	Yield Stress/0.2% Proof Stress					N/mm ²	540 min.				
	Elongation on 5D					%	17 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		-	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

