



WB6048 M.I.G. WELDING WIRE

Classifications	AWS A5.28-79 : ER110S-G									
Product Description	Copper coated Chromium-Nickel-Molybdenum solid MIG wire.									
Applications	<p>WB6048 is a solid MIG wire for the welding of high strength steels.</p> <p>Widely used for the welding of steels with a tensile strength of 750/850 N/mm², such as RQT600, HY80, NAXTRA 70 and T1.</p> <p>The balanced Manganese and Silicon ensures optimum deoxidisation and weld fluidity.</p>									
Wire Composition(Weight %)	C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu (total)
min.	0.07	1.40	0.30	-	-	1.20	0.20	0.20	-	-
max.	0.12	1.80	0.75	0.015	0.015	1.60	0.40	0.35	0.03	0.30
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		790 min.					
	Yield Stress/0.2% Proof Stress		N/mm ²		690 min.					
	Elongation on 5D		%		18 min.					
	Impact Energy CV @ -50°C as-welded		Joules		47 min.					

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

