

WB6105-Ni1 METAL CORED WELDING WIRE

Classifications	AWS A5.36: E80T15-M21A8-Ni1-H4 BSEN17632-A : T5061NiMM1H5									
Product Description	Copper coated, tubular, 1% Nickel, metal cored, welding wire. Fully positional.									
Applications	<p>WB6105-Ni/WB6105S-Ni is ideal for general and high integrity, low temperature (-60°C) fabrication applications. Excellent deposition rates due to metal powder technology.</p> <p>Tubular technology & copper coating ensures very low weld metal hydrogen levels (<3ml/100g) coupled with excellent current tip transfer. Excellent welder appeal including deslag and low spatter levels.</p> <p>Recommend for the welding of mild/medium tensile steels (UNI 510). Typical used for off-shore structures, ship-building, bridges etc.</p>									
Wire Composition(Weight %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
min.	0.04	1.10	0.40	-	-	-	0.70	-	-	-
max.	0.08	1.65	0.80	0.025	0.025	0.10	1.00	0.1	0.30	0.10
Typical All-Weld Metal Mechanical Properties	<p>Ultimate Tensile Strength N/mm² *583 **559</p> <p>Yield Stress/0.2% Proof Stress N/mm² *546 **504</p> <p>Elongation on 5D % *26.3 **29.2</p> <p>Impact Energy CV @ -60°C Joules *79 **87</p> <p>*as-welded</p> <p>**PHWT 620oC/1 hour</p>									

Wire Dia (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	150	160	180	-	-
	max.	-	-	240	260	300	-	-
Volt Range (Volts)	min.	-	-	17	20	20	-	-
	max.	-	-	24	30	31	-	-
Packaging Information								
Kg Per Reel		-	-	5/16	5/16	5/16	-	-
Storage	<p>Storage</p> <p>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%.</p>							
Gases	<p>Gas</p> <p>CO₂ or Argon/CO₂ mixture</p> <p>Flow Rate</p> <p>12-16 l/min</p>							

Current Conditions DC+ and Welding Positions

