



WB6105 METAL CORED WELDING WIRE

Classifications	AWS A5:36 : E70T15-M21A8-CS1-H4 BSENISO 17632 : T466MM1H5 TUV									
Product Description	Copper coated, tubular, metal cored, welding wire. Fully positional.									
Applications	WB6105 is ideal for general fabrication applications. Excellent deposition rates due to metal powder technology. 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. Recommend for the welding of mild/medium tensile steels up to grade 50D, having a tensile strength of ~500 N/mm ² , Lloyds A and D ship steel, BS1449 plate and sheet.									
Wire Composition(Weight %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
min.	0.04	1.10	0.40	-	-	-	-	-	-	-
max.	0.08	1.65	0.80	0.025	0.025	0.10	0.15	0.10	0.30	0.10
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		510-660		**602 ***587			
	Yield Stress/0.2% Proof Stress		N/mm ²		420 min.		**511 ***502			
	Elongation on 5D		%		22 min.		**26 ***28			
	Impact Energy CV @ -40°C as-welded		Joules		47 min.		**54 ***65			
	** actuals ***PHWT @ 620°C/1 hour									

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	18	20	-	-
	max.	-	-	24	26	29	-	-
Packaging Information								
Kg Per Reel		-	-	16	16	16	-	-
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 or Argon/CO ₂ mixture							
	Flow Rate 12-16 l/min							

Current Conditions DC+ and Welding Positions

