



# WB6500 T.I.G. WELDING WIRE

**Classifications**

AWS A5.18-95 : ER70S-6

BSEN440-95 : GH462MG3Si1

**Product Description**

Copper Coated, Carbon-Manganese Steel Solid TIG Wire.

**Applications**

Suitable for welding and repairing most C-Mn steels.

**Wire Composition(Weight %)**

	C	Mn	Si	S	P	Ni	Cr	Mo	Cu (total)
<b>min.</b>	0.06	1.30	0.75	-	-	-	-	-	-
<b>max.</b>	0.12	1.60	1.00	0.025	0.025	0.15	0.15	0.15	0.30

**Typical All-Weld Metal Mechanical Properties**

Ultimate Tensile Strength	N/mm <sup>2</sup>	510 min.
Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	430 min.
Elongation on 5D	%	22 min.
Impact Energy CV @ -20°C as-welded	Joules	>80

Wire Dia x 1000 Length(mm)	0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>min.</b>	-	-	-	-	80	80	80
<b>Current Range (Amps)</b>							
<b>max.</b>	-	-	-	-	120	120	120
<b>Volt Range (Volts)</b>							
<b>min.</b>	-	-	-	-	-	-	-
<b>max.</b>	-	-	-	-	-	-	-

**Packaging Information****Kg Per Tube**

- - - - 5 5 5

**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**

Pure Argon

**Flow Rate**

7-10 l/min

**Current Conditions DC- and Welding Positions**