WB6510 T.I.G. WELDING WIRE

Classifications	AWS A5.18-95 : ER70S-2 BS EN ISO 636-A 2008 : 46 4 W2Ti
Product Description	Copper coated Carbon-Manganese steel solid TIG wire.
Applications	Triple deoxidised, A15 type TIG wire suitable for welding and repairing C-Mn steels.

Wire Composition(Weight %)	C	Mn	Si	S	P	Ni	Cr	Mo	Al	V
min.	0.04	0.90	0.40	-	-	-	-	-	0.05	-
max.	0.14	1.40	0.80	0.025	0.025	0.15	0.15	0.15	0.20	0.03

	Cu	Ti	Zr	Ti+Zr
min.	-	0.05	0.02	0.05
max.	0.35	0.15	0.12	0.25

Typical All-Weld Metal Mechanical Properties			
Ultimate Tensile Strength	N/mm²	530-680	*609
Yield Stress/0.2% Proof Stress	N/mm²	460 min.	*578
Elongation on 5D	%	20 min.	*28
Impact Energy CV @ -40°C as-welded	Joules	47min.	*87
		*actual	

Wire Dia x 1000 Length(mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	**min.**	-	-	-	-	80	80	80
	max.	-	-	-	-	120	120	120
Volt Range (Volts)	**min.**	-	-	-	-	-	-	-
	max.	-	-	-	-	-	-	-
Packaging Information **Kg Per Tube**		-	-	-	-	5.0	5.0	5.0

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