



WB6540 T.I.G. WELDING WIRE

Classifications

AWS A5.28-79 : ER80S-Ni2

BSEN440-95 : G506MG2Ni2

Product Description

Copper coated 2% Nickel solid TIG wire.

Applications

WB6540 is a solid TIG wire for the welding of low temperature steels down to -50°C. The balanced Manganese and Silicon ensures optimum deoxidisation and weld fluidity.

Wire Composition(Weight %)

	C	Mn	Si	S	P	Ni	Cr	Mo
min.	0.05	0.90	0.40	-	-	2.20	-	-
max.	0.10	1.25	0.80	0.025	0.025	2.50	0.15	0.015

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm ²	560-720
Yield Stress/0.2% Proof Stress	N/mm ²	500 min.
Elongation on 5D	%	18 min.
Impact Energy CV @ -60°C as-welded	Joules	47min.

Wire Dia (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
min.		-	-	-	-	80	80	80
Current Range (Amps)	max.	-	-	-	-	120	120	120
Volt Range (Volts)	min.	-	-	-	-	-	-	-
	max.	-	-	-	-	-	-	-

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

