



WB6541 T.I.G. WELDING WIRE

Classifications AWS A5.28-79 : ER80S-D2 BSEN440-95 : G463MG2Mo

Product Description Copper coated Carbon-Manganese-Molybdenum solid TIG wire.

Applications High strength TIG wire for welding high strength steels with good sub zero notch toughness in the PWHT condition.

Wire Composition(Weight %)		C	Mn	Si	S	P	Ni	Cr	Mo	Cu (total)
min.		0.07	0.80	0.50	-	-	-	-	0.40	-
max.		0.12	1.40	0.90	0.025	0.025	0.15	0.15	0.60	0.30

Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength	N/mm ²	530-680
	Yield Stress/0.2% Proof Stress	N/mm ²	460 min.
	Elongation on 5D	%	20 min.
	Impact Energy CV @ -30°C as-welded	Joules	47min.

Wire Dia (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	-	-	-	-	7.5	7.5	7.5
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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

