



WB6541E T.I.G. WELDING WIRE

Classifications

~AWS A5.28-79 : ER80S-D2/ER90S-D2

BSEN440-95 : G463MG4Mo

Product Description

Copper coated Carbon-Manganese-Molybdenum solid TIG wire.

Applications

High strength (A31 type) 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	1.60	0.50	-	-	-	-	0.40	-
max.	0.12	2.10	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	550 min. **655
Yield Stress/0.2% Proof Stress	N/mm ²	460 min. **543
Elongation on 5D	%	20 min. ** 34
Impact Energy CV @ -50°C	Joules	47min. **59
Impact Energy CV @ -70°C	Joules	35 min. **42
as-welded		
** actual results		

Wire Dia (mm)

	0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
min.	-	-	-	-	80	80	80
max.	-	-	-	-	120	120	120
min.	-	-	-	-	-	-	-
max.	-	-	-	-	-	-	-

Packaging Information

Kg Per Tube

-	-	-	-	5	5	5
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Storage

Storage

It is recommended that the WB range of consumables are stored in a dry heated store at a minimum temperature of 16°C, and a maximum relative humidity of 60%. To avoid damage to the coatings no more than 9 cartons should be staked on top of another.

Gases

Gas

Pure Argon

Flow Rate

7-10 l/min

Current Conditions DC- and Welding Positions

