



## WB6013 MIG/MAG WELDING WIRE

<b>Classifications</b>	<b>AWS A5.28:</b> ER80S-Ni1 <b>BS EN ISO 14341-A:</b> G 46 6 M 3 Ni1																								
<b>Product Description</b>	Copper coated 1% Nickel solid wire for MIG/MAG welding.																								
<b>Applications</b>	<p>WB6013 is a solid wire for the welding of low temperature steels such as A333 Grade 6 or equivalent, with excellent notch toughness values down to -60°C. The Nickel content of WB6013 is such that compliance with N.A.C.E. specification is ensured.</p> <p>The balanced Manganese and Silicon ensures optimum deoxidisation and weld fluidity.</p> <p>Can also be used for the welding of weathering steels, such as Cor-Ten A and Cor-Ten B.</p>																								
<b>Wire Composition (Wt. %)</b>																									
	C	Mn	Si	S	P	Ni	Cr	Mo																	
<b>min.</b>	0.07	0.70	0.40	-	-	0.70	-	-																	
<b>max.</b>	0.12	1.25	0.60	0.020	0.020	1.00	0.15	0.015																	
<b>Typical All-Weld Metal Mechanical Properties</b>	<table> <tr> <td>Ultimate Tensile Strength</td> <td>N/mm<sup>2</sup></td> <td>590 min.</td> </tr> <tr> <td>Yield Stress/0.2% Proof Stress</td> <td>N/mm<sup>2</sup></td> <td>470 min.</td> </tr> <tr> <td>Elongation on 5D</td> <td>%</td> <td>20 min.</td> </tr> <tr> <td>Impact Energy CV @ -60°C</td> <td>Joules</td> <td>35min.</td> </tr> <tr> <td>As welded</td> <td></td> <td></td> </tr> </table>										Ultimate Tensile Strength	N/mm <sup>2</sup>	590 min.	Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	470 min.	Elongation on 5D	%	20 min.	Impact Energy CV @ -60°C	Joules	35min.	As welded		
Ultimate Tensile Strength	N/mm <sup>2</sup>	590 min.																							
Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	470 min.																							
Elongation on 5D	%	20 min.																							
Impact Energy CV @ -60°C	Joules	35min.																							
As welded																									

<b>Wire Dia. (mm)</b>		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>min.</b>	-	80	100	160	180	-	-
	<b>max.</b>	-	200	270	300	380	-	-
<b>Volt Range (Volts)</b>	<b>min.</b>	-	17	17	18	20	-	-
	<b>max.</b>	-	20	22	26	32	-	-
<b>Packaging Information</b>								
<b>Kg Per Reel</b>		-	15	15	15	15	-	-
<b>Storage</b>	<p><b>Storage</b></p> <p>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%.</p>							
<b>Gases</b>	<p><b>Gas</b></p> <p>CO<sub>2</sub> and Argon/CO<sub>2</sub> mixture</p> <p><b>Flow Rate</b></p> <p>15-20 L/min</p>							

### Current Conditions DC+ and Welding Positions

