



WB59M MAG WELDING WIRE

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|---|---|------|-------------------|---------|----------|------|------|-----|-----|------|------|
| Classifications | AWS A5.14: ERNiCrMo-13 BS EN ISO 18274: NiCr23Mo16 | | | | | | | | | | |
| Product Description | WB59M is MAG wire for the welding Ni-Cr-Mo base alloys. | | | | | | | | | | |
| Applications | WB59M is extensively used in the offshore / marine industry. Excellent pitting resistance. Typical materials to be welded: - Alloy 625, C-276, C22, and other high strength alloys such as 6Mo stainless. Some typical base metals that this alloy is used on are ASTM and ASME B an SB 574, 575, 619, 625 & 625. | | | | | | | | | | |
| All-Weld Metal Composition (Wt. %) | min. | C | Mn | Ni Bal. | Si | S | P | Co | Fe | Mo | Cu |
| | max. | 0.01 | 0.50 | - | 0.10 | 0.01 | 0.01 | 0.3 | 1.5 | 15.0 | 0.50 |
| | min. | Al | Ti | Cr | | | | | | | |
| | max. | 0.4 | 0.40 | 24.0 | | | | | | | |
| Typical All-Weld Metal Mechanical Properties | Ultimate Tensile Strength | | N/mm ² | | 700 min. | | | | | | |
| | Yield Stress/0.2% Proof Stress | | N/mm ² | | 400 min. | | | | | | |
| | Elongation on 4D | | % | | 30 min. | | | | | | |
| | Impact Energy CV @ -196°C | | Joules | | 70 min. | | | | | | |
| | As welded | | | | | | | | | | |

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|--|---|-------|-------|-------|-------|-------|-------|-------|
| Wire Dia. (mm) | | 0.6mm | 0.8mm | 1.0mm | 1.2mm | 1.6mm | 2.4mm | 3.2mm |
| Current Range (Amps) | min. | - | 60 | 75 | 130 | - | - | - |
| | max. | - | 170 | 250 | 280 | - | - | - |
| Volt Range (Volts) | min. | - | 18 | 18 | 18 | - | - | - |
| | max. | - | 26 | 28 | 28 | - | - | - |
| Packaging Information Kg Per Reel | | - | 15.0 | 15.0 | 15.0 | - | - | - |
| 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 Argon & Helium or 98% Argon / 1% Oxygen Flow Rate 15-20 L/min | | | | | | | |

Current Conditions DC+ and Welding Positions

