



## WB6513 TIG WELDING WIRE

Classifications	AWS A5.28: ER80S-Ni1									
ASME IX Qualification	QW432 F-No 6, QA442 A-No 10									
Product Description	Copper coated 1% Nickel solid TIG wire.									
Applications	WB6513 is a solid TIG wire for the welding of high strength, low temperature steels such as A333 Grade 6 or equivalent, with excellent notch toughness values down to - 60°C. The Nickel content of WB6513 is such that compliance with N.A.C.E. specification is ensured. The balanced Manganese and Silicon ensures optimum deoxidisation and weld fluidity. Can also be used for the welding of weathering steels, such as Cor-Ten A and Cor-Ten B.									
Wire Composition (Wt. %)	C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
min.	0.06	1.00	0.50	-	-	0.80	-	-	-	-
max.	0.12	1.25	0.80	0.020	0.020	1.00	0.15	0.30	0.03	0.30
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm <sup>2</sup>	590 min. **635			
	Yield Stress/0.2% Proof Stress					N/mm <sup>2</sup>	470 min. **546			
	Elongation on 5D					%	24 min. **27			
	Impact Energy CV @ -50°C					Joules	35 min. **195			
	Impact Energy CV @ -75°C					Joules	35 min. **165			
	As welded									
	**actual									

<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>	-	-	-	-	60	80	100
	<b>max.</b>	-	-	-	-	200	240	280
<b>Volt Range (Volts)</b>	<b>min.</b>	-	-	-	-	-	-	-
	<b>max.</b>	-	-	-	-	-	-	-
<b>Packaging Information</b>								
<b>Kg Per Tube</b>		-	-	-	-	5.0	5.0	5.0
<b>Storage</b>		<b>Storage</b> 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 stacked on top of another.						
<b>Gases</b>		<b>Gas</b> Pure Argon  <b>Flow Rate</b> 12-14 l/min						

### Current Conditions DC- and Welding Positions

