



WB6040 MIG/MAG WELDING WIRE

Classifications	AWS A5.28: ER80S-Ni2 BS EN ISO 14341-A: G 50 6 M 2 Ni2									
Product Description	Copper coated 2% Nickel solid MIG/MAG wire.									
Applications	WB6040 is a solid MIG/MAG wire for the welding of low temperature steels down to -50°C. The balanced Manganese and Silicon ensures optimum deoxidisation and weld fluidity.									
Wire Composition (Wt. %)										
	C	Mn	Si	S	P	Ni	Cr	Mo	Cu	
min.	0.05	0.90	0.40	-	-	2.00	-	-	-	-
max.	0.12	1.25	0.80	0.025	0.025	2.70	0.15	0.015	0.35	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		630					
	Yield Stress/0.2% Proof Stress		N/mm ²		530					
	Elongation on 5D		%		26					
	Impact Energy CV @ -60°C		Joules		>47min.					
	As welded									

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	80	120	160	180	-	-
	max.	-	180	240	280	360	-	-
Volt Range (Volts)	min.	-	17	17	18	20	-	-
	max.	-	20	22	29	32	-	-
Packaging Information								
Kg Per Reel		-	15	15	15	15	-	-
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 CO ₂ and Argon/CO ₂ mixture Flow Rate 15-20 L/min							

Current Conditions DC+ and Welding Positions

