



# WB6000 MIG/MAG WELDING WIRE

<b>Classifications</b>	<b>AWS A5.18:</b> ER70S-6 <b>BS EN ISO 14341-A:</b> G 46 4 M21 3Si1									
<b>Product Description</b>	Copper coated, Controlled Carbon-Manganese-Silicon steel solid wire for MIG/MAG welding. Fully positional in short-circuit transfer mode.									
<b>Applications</b>	Suitable for welding and repairing most C-Mn steels.									
<b>Wire Composition (Wt. %)</b>										
	C	Mn	Si	S	P	Ni	Cr	Mo	Cu (total)	
<b>min.</b>	0.06	1.30	0.75	-	-	-	-	-	-	-
<b>max.</b>	0.12	1.60	1.00	0.025	0.025	0.15	0.15	0.15	0.30	
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength				N/mm <sup>2</sup>		565			
	Yield Stress/0.2% Proof Stress				N/mm <sup>2</sup>		480			
	Elongation on 5D				%		32			
	Impact Energy CV @ -30°C				Joules		>90			
	Impact Energy CV @ -40°C				Joules		>70			
	As welded									

<b>Wire Dia. (mm)</b>		0.6mm	0.8/0.9mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>min.</b>	-	70	80	100	180	-	-
	<b>max.</b>	-	180	240	300	380	-	-
<b>Volt Range (Volts)</b>	<b>min.</b>	-	15	15	15	20	-	-
	<b>max.</b>	-	20	22	30	32	-	-
<b>Packaging Information</b>								
<b>Kg Per Std Reel</b>		-	0.7 / 20	15/16/20	15/16/20	15/16/20	-	-
<b>Kg Per Bulk Reel</b>			250/350	250/350	250/350	250/350		
<b>Storage</b>	<b>Storage</b> 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%.							
<b>Gases</b>	<b>Gas</b> CO <sub>2</sub> and Argon/CO <sub>2</sub> mixture				<b>Flow Rate</b> 15-20 L/min			

## Current Conditions DC+ and Welding Positions

