WB6591 TIG WELDING WIRE

Classifications	**AWS A5.28:** ER90S-G
Product Description	Copper coated Nickel-Molybdenum solid TIG wire.
Applications	WB6591 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 WB6591 is such that compliance with N.A.C.E. specification is ensured. The balanced Manganese and Silicon ensures optimum deoxidisation and weld fluidity.

Wire Composition (Wt. %)

	C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu
min.	0.08	1.50	0.30	-	-	0.80	-	0.35	-	-
max.	0.14	2.00	0.70	0.015	0.020	1.00	0.10	0.55	0.05	0.15

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm²	690 min.
Yield Stress/0.2% Proof Stress	N/mm²	610 min.
Elongation on 5D	%	16 min.
Impact Energy CV @ -40°C	Joules	38 min.

As welded

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.0mm
Current Range (Amps)	**min.**	-	-	-	-	60	80	100
	max.	-	-	-	-	120	160	200
Volt Range (Volts)	**min.**	-	-	-	-	-	-	-
	max.	-	-	-	-	-	-	-
Packaging Information								
Kg Per Tube		-	-	-	-	5.0	5.0	5.0

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** Pure Argon **Flow Rate** 12-14 L/min

Current Conditions DC- and Welding Positions

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