



WB6510 TIG WELDING WIRE

Classifications	AWS A5.18: ER70S-2		BS EN ISO 636-A: 46 4 W2Ti							
Product Description	Copper coated Carbon-Manganese steel solid TIG wire.									
Applications	Triple deoxidised, A15 type TIG wire suitable for welding and repairing C-Mn steels.									
Wire Composition (Wt. %)	C	Mn	Si	S	P	Ni	Cr	Mo	Al	V
	min. 0.04 max. 0.07	0.90 1.40	0.40 0.80	- 0.025	- 0.025	- 0.15	- 0.15	- 0.15	0.05 0.20	- 0.03
	Cu	Ti	Zr	Ti+Zr						
	min. - max. 0.35	0.05 0.15	0.02 0.12	0.05 0.25						
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength				N/mm ²	530-680 *609				
	Yield Stress/0.2% Proof Stress				N/mm ²	460 min. *578				
	Elongation on 5D				%	20 min. *28				
	Impact Energy CV @ -40°C				Joules	47min. *87				
	As welded					*Actual				

Wire Dia. x 1000 Length(mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	-	-	60	80	80
	max.	-	-	-	-	180	200	240
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

