



WB6541 TIG WELDING WIRE

Classifications	AWS A5.28: ER80S-G (A1) BS EN ISO 21952-A: MoSi									
Product Description	Copper coated Carbon-Manganese-Molybdenum solid TIG wire.									
Applications	Low alloyed TIG wire for welding high strength steels. Suitable for welding low alloy and creep resistant steels with good sub-zero notch toughness in the PWHT condition. Common choice for pipe and tank constructions.									
Wire Composition (Wt. %)										
	C	Mn	Si	S	P	Ni	Cr	Mo	Cu (total)	
min.	0.07	0.80	0.50	-	-	-	-	0.40	-	
max.	0.12	1.40	0.90	0.025	0.025	0.15	0.15	0.60	0.30	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		530-680					
	Yield Stress/0.2% Proof Stress		N/mm ²		460 min.					
	Elongation on 5D		%		20 min.					
	Impact Energy CV @ -30°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	80	80
	max.	-	-	-	-	120	160	180
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

