



# WB6500 TIG WELDING WIRE

<b>Classifications</b>	<b>AWS A5.18:</b> ER70S-6 <b>BS EN ISO 636-A:</b> W42 3 W3Si1									
<b>Product Description</b>	Copper coated, Carbon-Manganese steel solid TIG wire.									
<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)	
min.	0.06	1.30	0.70	-	-	-	-	-	-	-
max.	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>			510 min.			
	Yield Stress/0.2% Proof Stress			N/mm <sup>2</sup>			430 min.			
	Elongation on 5D			%			22 min.			
	Impact Energy CV @ -40°C			Joules			>80			
	As welded									

<b>Wire Dia. x 1000 Length(mm)</b>		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	min.	-	-	-	-	60	80	80
	max.	-	-	-	-	120	140	160
<b>Volt Range (Volts)</b>	min.	-	-	-	-	-	-	-
	max.	-	-	-	-	-	-	-
<b>Packaging Information</b>								
<b>Kg Per Tube</b>		-	-	-	-	7.5	7.5	7.5
<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> Pure Argon  <b>Flow Rate</b> 12-14 l/min							

### Current Conditions DC- and Welding Positions

