WB6547P TIG WELDING WIRE

Classifications	AWS A5.28: ER100S-G
Product Description	Copper coated Manganese-Nickel-Molybdenum solid TIG wire for welding high tensile, notch-tough steels.
Applications	WB6547P is a solid TIG wire suitable for welding tempered, high-tensile, fine-grained structural steels, such as in the construction of piplines, containers and associated appliances. Widely used for the welding of steels with a tensile strength of 700/800 N/mm², such as RQT600, HY80, NAXTRA 70 while meeting NACE requirements. The balanced Manganese and Silicon ensures optimum deoxidisation and weld fluidity.

Wire Composition (Wt. %)

	C	Mn	Si	S	P	Ni	Cr	Mo	Al	Ti
min.	0.06	1.65	0.30	-	-	0.70	-	0.30	-	0.10
max.	0.10	1.90	0.70	0.010	0.015	1.00	0.10	0.50	0.05	0.15

Typical All-Weld Metal Mechanical Properties

			Typical
Ultimate Tensile Strength	N/mm²	690 min.	815
Yield Stress/0.2% Proof Stress	N/mm²	610 min.	771
Elongation on 5D	%	16 min.	22
Impact Energy CV @ -40°C	Joules	38 min.	81, 76, 76

As welded

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	**min.**	-	-	-	-	70	90	100
	max.	-	-	-	-	160	180	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