



WB6042 MIG/MAG WELDING WIRE

Classifications	AWS A5.28: ER80S-B2 BS EN ISO 21952-A: G CrMo1Si										
Product Description	Copper coated 1.25% Chromium, 0.5% Molybdenum solid MAG wire.										
Applications	<p>WB6042 is suitable for welding 1.25%Cr 0.5%Mo creep-resisting steels.</p> <p>The balanced Manganese and Silicon ensures optimum deoxidisation and weld fluidity.</p> <p>Typical grades:- BS1501:Part 2 620, BS1503 Grade 620/621, BS1504 Grade 620 and BS3100 Grade B2, ASTM A335 Grades P11 & P12, A182 F11, ASTM A199, A200 & A213.</p> <p>Scaling and creep resistance to 550°C.</p>										
Wire Composition (Wt. %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	
min.		0.08	0.80	0.40	-	-	1.10	-	0.45	-	
max.		0.12	1.20	0.80	0.025	0.025	1.50	0.03	0.65	0.10	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		550-650						
	Yield Stress/0.2% Proof Stress		N/mm ²		470 min.						
	Elongation on 5D		%		22 min.						
	Impact Energy CV @ +20°C		Joules		47min.						
	Stress relieved @ 690°C / 1Hr										

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	80	120	160	180	-	-
	max.	-	180	240	300	380	-	-
Volt Range (Volts)	min.	-	17	17	18	20	-	-
	max.	-	20	22	28	30	-	-
Packaging Information								
Kg Per Reel		-	15	15	15	15	-	-
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 CO ₂ and Argon/CO ₂ mixture Flow Rate 15-20 L/min							

Current Conditions DC+ and Welding Positions

