



WB6513 TIG WELDING WIRE

Classifications	AWS A5.28: ER80S-Ni1-H4 BS EN ISO 636-A: W 46 5 W3Ni1								
ASME IX Qualification	QW432 F-No 6, QA442 A-No 10								
Product Description	Copper coated 1% Nickel solid TIG wire.								
Applications	<p>WB6513 is a solid TIG wire for the welding of high strength, low temperature steels such as A333 Grade 6 or equivalent, with excellent notch toughness values down to -60°C.</p> <p>The Nickel content of WB6513 is such that compliance with N.A.C.E. specification is ensured. The balanced Manganese and Silicon ensures optimum deoxidisation and weld fluidity. Can also be used for the welding of weathering steels, such as Cor-Ten A and Cor-Ten B.</p>								
Wire Composition(Weight %)									
	C	Mn	Si	S	P	Ni	Cr	Mo	
min.	0.07	1.00	0.50	-	-	0.80	-	-	
max.	0.12	1.50	0.80	0.020	0.020	1.00	0.15	0.15	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		590 min. **635				
	Yield Stress/0.2% Proof Stress		N/mm ²		470 min. **546				
	Elongation on 5D		%		20 min. **23				
	Impact Energy CV @ -50°C		Joules		35 min. **195				
	Impact Energy CV @ -75°C		Joules		35 min. **165				
	As welded								
	**actual								

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	120	120
Volt Range (Volts)	min.	-	-	-	-	-	-	-
	max.	-	-	-	-	-	-	-
Packaging Information								
Kg Per Tube		-	-	-	-	5.0	5.0	5.0
Storage	<p>Storage</p> <p>It is recommended that the WB range of consumables are stored in a dry heated store at a minimum temperature of 16°C, and a maximum relative humidity of 60%. To avoid damage to the coatings no more than 9 cartons should be staked on top of another.</p>							
Gases	<p>Gas</p> <p>Pure Argon</p> <p>Flow Rate</p> <p>12-14 l/min</p>							

Current Conditions DC- and Welding Positions

