WB6105-NiCu METAL CORED WELDING WIRE

Classifications	**AWS A5.28:** E80C-GH4 **BS EN ISO 17632-A:** T46 6 Z M M21 1 H5 **AWS A5.36:** E81T15-M21A8-GH4
Product Description	Formed, 0.5% Nickel, 0.5% Copper metal cored, welding wire.
Applications	WB6105-NiCu is ideal for general and high integrity, low temperature (-60°C) weathering steel fabrication applications. Excellent rooting characteristics and deposition rates due to metal powder technology. High integrity manufacturing technology ensures very low weld metal hydrogen levels (<3ml/100g) coupled with excellent current tip transfer. Excellent welder appeal including deslag and low spatter levels. Recommend for the welding of weathering/medium tensile steels (UNI 510). Typically used for offshore structures, shipbuilding, bridges etc. In addition, this product can be used for pipe/structural rooting.

Wire Composition (Wt. %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
min.	0.04	1.10	0.40	-	-	-	0.40	-	0.40	-
max.	0.08	1.65	0.80	0.025	0.025	0.10	0.70	0.1	0.70	0.10

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm²	550-640
Yield Stress/0.2% Proof Stress	N/mm²	>420
Elongation on 5D	%	>22
Impact Energy CV @ -60°C As welded	Joules	27 min.

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	**min.**	-	-	150	160	180	-	-
	max.	-	-	240	280	380	-	-
Volt Range (Volts)	**min.**	-	-	17	18	20	-	-
	max.	-	-	24	26	29	-	-
Packaging Information **Kg Per Reel**		-	-	16	5/16	16	-	-

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	**Flow Rate**
Argon/CO_2 mixture	15-20 L/min

Current Conditions DC+ and Welding Positions

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