



## WB6512 TIG WELDING WIRE

<b>Classifications</b>	<b>AWS A5.28: ER80S-G</b>									
<b>Product Description</b>	Copper coated; Cor-Ten type solid TIG wire.									
<b>Applications</b>	<p>WB6512 is suitable for welding Cor-Ten type weathering steels. In addition, the product is also used for welding and fabricating seawater injection lines for the offshore and marine industry.</p> <p>Typical grades: - Cor-ten A, B, Patinax and BS4360-50A</p>									
<b>Wire Composition (Wt. %)</b>										
	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	
<b>min.</b>	0.08	1.20	0.70	-	-	0.10	0.70	-	0.25	
<b>max.</b>	0.11	1.50	0.90	0.025	0.025	0.30	0.90	0.15	0.45	
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength		N/mm <sup>2</sup>		600-660					
	Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>		550 min.					
	Elongation on 5D		%		22 min.					
	Impact Energy CV @ -60°C		Joules		47min.					
	As welded									

<b>Wire Dia. (mm)</b>		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>min.</b>	-	-	-	-	60	80	100
	<b>max.</b>	-	-	-	-	180	200	240
<b>Volt Range (Volts)</b>	<b>min.</b>	-	-	-	-	-	-	-
	<b>max.</b>	-	-	-	-	-	-	-
<b>Packaging Information</b>								
<b>Kg Per Tube</b>		-	-	-	-	5	5	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

