



## 6105-Ni1 METAL CORED WELDING WIRE

<b>Classifications</b>	<b>AWS A5.28:</b> E80C-Ni1H4 <b>BS EN ISO 17632-A:</b> T50 6 1Ni M M21 1 H5 <b>AWS A5.36:</b> E80T15-M21A8-Ni1-H4									
<b>Product Description</b>	Copper coated, tubular, 1% Nickel, metal cored, welding wire. Fully positional.									
<b>Applications</b>	6105-Ni1 is ideal for general and high integrity, low temperature (-60°C) fabrication applications. Excellent deposition rates due to metal powder technology. Seamless tubular technology & copper coating ensures very low weld metal hydrogen levels (<3ml/100g) coupled with excellent current tip transfer. Excellent welder appeal with low spatter levels and no surface slag formation meaning no removal required. Recommend for the welding of mild/medium tensile steels (UNI 510). Typical used for offshore structures, shipbuilding, bridges etc.									
<b>Wire Composition (Wt. %)</b>	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
<b>min.</b>	0.04	1.10	0.40	-	-	-	0.70	-	-	-
<b>max.</b>	0.10	1.65	0.80	0.025	0.025	0.10	1.00	0.1	0.30	0.10
<b>Typical All Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength                      N/mm <sup>2</sup> 510-690 Yield Stress/0.2% Proof Stress            N/mm <sup>2</sup> 500 min. Elongation on 5D                                %                              22 min. Impact Energy CV @ -60°C                  Joules                      47 min. As welded								Typical 640 535 27 >80	

<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>	-	-	150	160	180	-	-
	<b>max.</b>	-	-	240	280	380	-	-
<b>Volt Range (Volts)</b>	<b>min.</b>	-	-	17	20	20	-	-
	<b>max.</b>	-	-	24	30	31	-	-
<b>Packaging Information</b>								
<b>Kg Per Reel</b>		-	-	5/16	5/16	5/16	-	-
<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> CO <sub>2</sub> or Argon/CO <sub>2</sub> mixture				<b>Flow Rate</b> 15-20 L/min			

### Current Conditions DC+ and Welding Positions

