



# WB6041E MIG/MAG WELDING WIRE

<b>Classifications</b>	<b>AWS A5.28:</b> ER80S-D2/ER90S-D2 <b>BS EN 14341-A:</b> G 50 5 M21 4Mo								
<b>Product Description</b>	Copper coated Carbon-Manganese-Molybdenum solid wire for MIG/MAG welding.								
<b>Applications</b>	High strength wire for welding high strength steels with good sub-zero notch toughness in the PWHT condition.								
<b>Wire Composition (Wt. %)</b>	C	Mn	Si	S	P	Ni	Cr	Mo	Cu (total)
<b>min.</b>	0.07	1.70	0.50	-	-	-	-	0.40	-
<b>max.</b>	0.12	2.00	0.90	0.025	0.025	0.15	0.15	0.65	0.30
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength		N/mm <sup>2</sup>		690-745		**540		
	Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>		590-640		**625		
	Elongation on 5D		%		27-31		**30		
	Impact Energy CV @ -50°C		Joules		90 avg.		**120 (-46°C)		
	*As welded								
	** 650°C for 4 hours								

<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>	-	80	120	160	180	-	-
	<b>max.</b>	-	180	240	300	360	-	-
<b>Volt Range (Volts)</b>	<b>min.</b>	-	17	17	18	20	-	-
	<b>max.</b>	-	20	22	29	32	-	-
<b>Packaging Information</b>								
<b>Kg Per Reel</b>		-	15/16	15/16	15/16	15/16	-	-
<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> and Argon/CO <sub>2</sub> mixture  <b>Flow Rate</b> 15-20 L/min							

## Current Conditions DC+ and Welding Positions

