

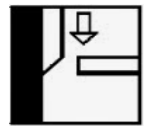
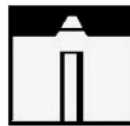
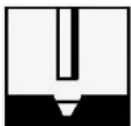


WB6105 METAL CORED WELDING WIRE

Classifications	AWS A5:18: E70C-6MH4 BS EN ISO 17632-A: T46 6 M M21 1 H5 AWS A5:36: E70T15-M21A8-CS1-H4										
Product Description	Copper coated, seamless tubular, metal cored, welding wire. Fully positional.										
Applications	WB6105 is ideal for general fabrication applications. Excellent deposition rates due to metal powder technology. Seamless tubular technology & copper coating ensures very low weld metal H ₂ 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 up to grade 50D, having a tensile strength of ~500 N/mm ² , Lloyds A and E ship steel, BS1449 plate and sheet.										
Wire Composition (Wt. %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
	min.	0.04	1.10	0.40	-	-	-	-	-	-	-
	max.	0.08	1.65	0.80	0.025	0.025	0.10	0.15	0.10	0.30	0.10
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		550-660		**602		***587		
	Yield Stress/0.2% Proof Stress		N/mm ²		460 min.		**511		***502		
	Elongation on 5D		%		22 min.		**26		***28		
	Impact Energy CV @ -40°C		Joules		47 min.		**59		***69		
	As welded ** actuals ***PWHT @ 620°C/1 hour										

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	150	100	180	-	-
	max.	-	-	240	280	380	-	-
Volt Range (Volts)	min.	-	-	17	15	20	-	-
	max.	-	-	24	28	30	-	-
Packaging Information								
Kg Per Reel		-	-	5/16	5/16	5/16	-	-
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 CO ₂ or Argon/CO ₂ mixture				Flow Rate 15-20 L/min			

Current Conditions DC+ and Welding Positions



Approvals: LR (5Y46S), CWB, CE