WB6012M MIG/MAG WELDING WIRE

Classifications	**AWS A5.28:** ER80S-G **BS EN ISO 14341-A:** G Z 3Ni1Cu
Product Description	Copper coated, Cor-Ten type solid wire for MIG/MAG welding.
Applications	WB6012 is suitable for welding Cor-Ten type weathering steels. Typical grades: - Cor-ten A, B, Patinax and BS4360-50A

Wire Composition (Wt. %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
min.	0.08	1.20	0.70	-	-	-	0.60	-	0.25
max.	0.11	1.50	0.90	0.025	0.025	0.15	0.90	0.15	0.45

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm²	550-660
Yield Stress/0.2% Proof Stress	N/mm²	430 min.
Elongation on 5D	%	22 min.
Impact Energy CV @ -20°C	Joules	47min.

As welded

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	**min.**	-	80	120	160	180	-	-
	max.	-	180	250	300	380	-	-
Volt Range (Volts)	**min.**	-	17	17	18	20	-	-
	max.	-	20	24	29	32	-	-
Packaging Information **Kg Per Reel**		-	15	15	15	15	-	-

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 and Argon/CO_2 mixture

Flow Rate
15-20 L/min

Current Conditions DC+ and Welding Positions

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