



WB6047P MIG WELDING WIRE

Classifications	AWS A5.28: ER100S-G										
Product Description	Copper coated Chromium-Nickel-Molybdenum solid MIG wire.										
Applications	<p>WB6047P is a solid MIG wire for the welding of medium/high strength steels.</p> <p>Widely used for the welding of steels with a tensile strength of 600/700 N/mm², such as RQT600, HY80 and NAXTRA 70. Hardness <235BHN.</p> <p>The balanced Manganese and Silicon ensures optimum deoxidisation and weld fluidity.</p>										
Wire Composition (Wt. %)		C	Mn	Si	S	P	Ni	Cr	Mo	Al	Ti
min.		0.06	1.40	0.30	-	-	0.70	-	0.25	-	-
max.		0.12	1.80	0.70	0.015	0.020	1.00	0.20	0.45	0.05	0.15
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		750 min. **883						
	Yield Stress/0.2% Proof Stress		N/mm ²		690 min. **743						
	Elongation on 5D		%		16 min. **23						
	Impact Energy CV @ -40°C		Joules		47 min. **87						
	As welded										
	**690°C/2 hours										

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.	-	200	250	300	380	-	-
Volt Range (Volts)	min.	-	13	14	15	20	-	-
	max.	-	20	22	26	29	-	-
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

