

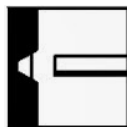


WB6541E TIG WELDING WIRE

Classifications	AWS A5.28: ER80S-D2 / ER90S-D2									
Product Description	Copper coated Carbon-Manganese-Molybdenum TIG wire.									
Applications	High strength (A31 type) TIG wire for welding high strength steels with good sub-zero notch toughness in the PWHT condition.									
Wire Composition (Wt. %)		C	Mn	Si	S	P	Ni	Cr	Mo	Cu (total)
min.		0.07	1.60	0.50	-	-	-	-	0.40	-
max.		0.12	2.10	0.90	0.025	0.025	0.15	0.15	0.60	0.30
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		550 min. **675					
	Yield Stress/0.2% Proof Stress		N/mm ²		460 min. **593					
	Elongation on 5D		%		20 min. ** 34					
	Impact Energy CV @ -50°C		Joules		47min. **59					
	Impact Energy CV @ -70°C		Joules		35 min. **42					
	As welded									
	** actual results									

Wire dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	-	-	60	80	100
	max.	-	-	-	-	120	160	200
Volt Range (Volts)	min.	-	-	-	-	-	-	-
	max.	-	-	-	-	-	-	-
Packaging Information								
Kg Per Tube		-	-	-	-	7.5	7.5	7.5
Storage	Storage It is recommended that the WB range of consumables are stored in a dry heated store at a minimum temperature of 16°C, and a maximum relative humidity of 60%. To avoid damage to the coatings no more than 9 cartons should be staked on top of another.							
Gases	Gas Pure Argon				Flow Rate 12-14 L/min			

Current Conditions DC- and Welding Positions



Approvals: CE