

WB6542 T.I.G. WELDING WIRE

Classifications	AWS A5.28 : ER80S-B2 EN ISO 21952-A : W CrMo1									
Product Description	Copper coated 1.25% Chromium, 0.5% Molybdenum solid TIG wire.									
Applications	WB6542 is suitable for welding 1.25%Cr 0.5%Mo creep-resisting steels. The balanced Manganese and Silicon ensures optimum deoxidisation and weld fluidity. Typical grades:- BS1501:Part 2 620, BS1503 Grade 620/621, BS1504 Grade 620 and BS3100 Grade B2, ASTM A335 Grades P11 & P12, A182 F11, ASTM A199, A200 & A213. Scaling and creep resistance to 550°C.									
Wire Composition(Weight %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	
min.	0.08	0.80	0.40	-	-	1.10	-	0.45	-	
max.	0.12	1.20	0.80	0.025	0.025	1.50	0.03	0.65	0.10	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm ²	550-650			
	Yield Stress/0.2% Proof Stress					N/mm ²	470 min.			
	Elongation on 5D					%	22 min.			
	Impact Energy CV @ +20°C					Joules	47min.			
	Stress relieved @ 690°C / 1Hr									

Wire Dia (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	-	-	80	80	80
	max.	-	-	-	-	120	120	120
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 wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.							
Gases	Gas Pure Argon Flow Rate 7-10 l/min							

Current Conditions DC- and Welding Positions

