



WB6105-NiMo METAL CORED WELDING WIRE

Classifications	AWS A5.28: E90C-K3H4 BS EN ISO 18276-A: T55 6 1NiMo M M21 1 H5 AWS A5.36: E91T15-M21A8-K1-H4									
Product Description	Copper coated, tubular, 1% Nickel 0.5% Molybdenum, metal cored wire welding. Fully positional.									
Applications	WB6105-NiMo is ideal for general and high integrity, low temperature (-60°C) fabrication applications. Excellent deposition rates due to metal powder technology. Seamless tubular technology & copper coating ensures very low weld metal hydrogen 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 medium/high tensile steels S460QL, S550QL. Typical used for offshore structures, pipelines, bridges etc.									
Wire Composition (Wt. %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	V
min.	0.03	-	-	-	-	-	0.60	0.30	-	-
max.	0.10	1.4	0.90	0.020	0.020	0.20	1.20	0.60	0.30	0.05
Typical All Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		*640		(>550)			
	Yield Stress/0.2% Proof Stress		N/mm ²		*740		(640-820)			
	Elongation on 5D		%		*22		(>18)			
	Impact Energy CV @ -60°C		Joules		*75		(>47)			
	As welded									

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	150	160	180	-	-
	max.	-	-	240	280	380	-	-
Volt Range (Volts)	min.	-	-	17	20	20	-	-
	max.	-	-	24	30	31	-	-
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

