



WB6542 TIG WELDING WIRE

Classifications	AWS A5.28: ER80S-B2 BS EN ISO 21952-A: W CrMo1Si										
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 (Wt. %)											
	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.	-	-	-	-	60	80	80
	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 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 12-14 L/min							

Current Conditions DC+ and Welding Positions

