



WB6512 T.I.G. WELDING WIRE

Classifications	AWS A5.28 : ER80S-G									
Product Description	Copper coated, Cor-Ten type solid TIG wire.									
Applications	<p>WB6512 is suitable for welding Cor-Ten type weathering steels. In addition the product is also used for welding and fabricating seawater injection lines for the offshore and marine industry.</p> <p>Typical grades:- Cor-ten A, B, Patinax and BS4360-50A</p>									
Wire Composition(Weight %)										
	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	
min.	0.08	1.20	0.70	-	-	0.20	0.60	-	0.25	
max.	0.11	1.50	0.90	0.025	0.025	0.40	0.90	0.15	0.45	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength				N/mm ²		550-660			
	Yield Stress/0.2% Proof Stress				N/mm ²		430 min.			
	Elongation on 5D				%		22 min.			
	Impact Energy CV @ -20°C as-welded				Joules		47min.			

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		-	-	-	-	5	5	5
Storage	<p>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%.</p>							
Gases	<p>Gas Pure Argon</p> <p>Flow Rate 7-10 l/min</p>							

Current Conditions DC- and Welding Positions



