MAGMA North America

WB6105

METAL CORED WELDING WIRE

Classifications	**AWS A5.36:** E70T15-M21A8-CS1-H4 **BS EN ISO 17632-A:** T46 6 M M21 H5									
Product Description	Copper coated, seamless tubular, metal cored welding wire. Fully positional.									
Applications	WB6105 is ideal for general fabrication applications. Excellent deposition rates due to metal powder technology. Seamless tubular technology and 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 mild/medium tensile steels up to grade 50D, having a tensile strength of ~500 N/mm^2, Lloyds A and E ship steel, BS1449 plate and sheet.									
Composition (Wt. %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
Min	0.04	1.10	0.40	-	-	-	-	-	-	-
Max	0.08	1.65	0.80	0.025	0.025	0.10	0.15	0.10	0.30	0.10

Typical All-Weld Metal Mechanical Properties				
Ultimate Tensile Strength	N/mm^2	550-660	**602	***587
Yield Stress/0.2% Proof Stress	N/mm^2	460 min.	**511	***502
Elongation on 5D	%	22 min.	**26	***28
Impact Energy CV @-40°C	Joules	47 min.	**59	***69

*As welded

**Stress Relieved @620°C/1Hr

Wire Diameter (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	**Min.**	-	-	150	100	180	-	-
	Max.	-	-	240	280	380	-	-
Volt Range (Volts)	**Min.**	-	-	17	15	20	-	-
	Max.	-	-	24	28	30	-	-
Packaging Information KG per Reel		-	-	5/16	5/16	5/16	-	-

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**	**Flow Rate**
	CO_2 or Argon/CO_2 mixture	15-20 L/min

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Current Conditions DC+ and Welding Positions

Approvals: LR 5Y46S, DNV-GL, CWB, TUV, ABS, CE

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