WB6105-Ni1

METAL CORED WELDING WIRE

Classifications	**AWS A5.36:** E80T15-M21A8-Ni1-H4 **BS EN ISO 17632-A:** T50 6 1Ni M M 1 H5
Product Description	Copper coated, tubular, 1% Nickel, metal cored welding wire. Fully positional.
Applications	WB6105-Ni1 is ideal for general and high integrity, low temperature (-60°C) 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 (UNI 510). Typical used for offshore structures, shipbuilding, bridges etc.

Composition (Wt. %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Al
Min	0.04	1.10	0.40	-	-	-	0.70-	-	-	-
Max	0.10	1.65	0.80	0.025	0.025	0.10	1.00	0.10	0.30	0.10

Typical All-Weld Metal Mechanical Properties				
Ultimate Tensile Strength	N/mm^2	*583	**559
Yield Stress/0.2% Proof Stress	N/mm^2	*546	**504
Elongation on 5D	%	*26.3	**29.2
Impact Energy CV @-60°C	Joules	*79	**87

*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	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	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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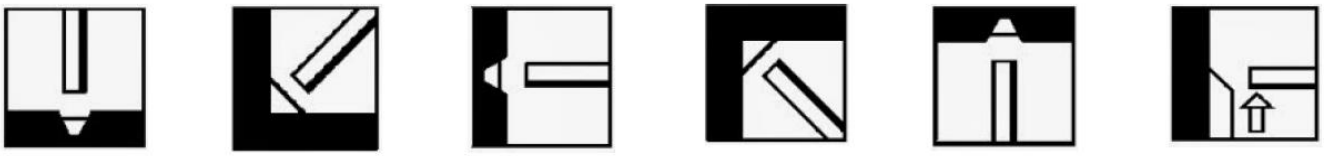
Current Conditions DC+ and Welding Positions



Approvals: DNV-GL, CWB, TUV, ABS, CE

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