

PRODUCT DATA SHEET

Afrox 6048



Afrox 6048 is a low alloy steel welding wire containing nickel, molybdenum and vanadium. The wire which is copper coated, is suitable for use in all positions. Afrox 6048 is recommended for welding a range of fine grained structural steels and low alloy quenched and tempered steels having an ultimate tensile strength of up to 930 MPa. The wire may be used with Argoshield® 5, Argoshield® Light, Argoshield® Heavy and Argoshield® Universal as well as CO₂ at flow rates of 14-16 l/min. Argon-based shielding gases are recommended.

Classifications

AWS	A5.28	ER 110S-G and ER 100S-G
EN	16834-A	W 69 4M Mn3Ni1 CrMo
EN	16834-B	W 76 A 4M N4M2 (nearest)

Typical Chemical Analysis

% Carbon	0,08 - 0,1	% Chromium	0,3 - 0,4
% Manganese	1,6 - 1,8	% Nickel	1,4 - 1,6
% Silicon	0,5 - 0,7	% Molybdenum	0,25 - 0,3
% Phosphorous	0,15 max	% Copper	0,35 max
% Sulphur	0,018 max	% Vanadium	0,09 - 0,11

Typical Mechanical Properties (All weld metal in the as welded condition)

Tensile Strength	>690 MPa
0,2% Proof Stress	>770 MPa
% Elongation on 5d	>17
Charpy V-Notch at -40°C	>47 J

Packing Data (DC-)

Diameter (mm)	Current		Pack Mass (kg)	Item Number
	Amps (A)	Volts (V)		
1,0	230	25	15,0	W078192
1,2	280	26	15,0	W033188
1,2	280	26	350,0	W033189

Suggested shielding gas: Argoshield® 5, Argoshield® Light, Argoshield® Heavy, Argoshield® Universal, 100% CO₂

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