WB307T T.I.G. WELDING WIRE

Classifications	AWS A5.9-81 : ER307
Product Description	307 stainless steel, solid TIG wire.
Applications	WB307T finds use in the joining, repairing and build-up of 13%Mn (Hadfield) steel castings. In addition can be used on mild, hardenable or stainless steels with little or no preheat.

Wire Composition(Weight %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	
min.	0.04	5.0	0.30	-	-	17.0	7.5	-	-	
max.	0.14	7.5	1.0	0.025	0.030	20.0	9.5	1.0	0.5	

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm²	550 min.
Yield Stress/0.2% Proof Stress	N/mm²	380 min.
Elongation on 4D	%	25 min.
Impact Energy CV @ +20°C as-welded	Joules	>100

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	**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** 7-10 l/min

Current Conditions DC- and Welding Positions