



WB312T T.I.G. WELDING WIRE

Classifications

AWS A5.9-81 : ER312

BSEN12072-00 : G29 9 TUV

Product Description

312 stainless steel, solid TIG wire.

Applications

WB312T is used mainly for welding and repairing steels of unknown specifications and for dissimilar welds between Ferritic and Austenitic steels. Also used for welding difficult to weld medium and high carbon steels, can also tolerate high rates of dilution.

Typical grades include :- 709M40 (En19), 070M55, BS970 Part 1, 080M40 (En8), 070M55 (En9).

Not recommended where PWHT is required or where materials will be subject to low temperature service.

Wire Composition(Weight %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
min.	-	1.0	0.30	-	-	28.0	8.0	-	-
max.	0.15	2.5	0.65	0.03	0.03	32.0	10.5	0.5	0.50

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm ²	650 min.
Yield Stress/0.2% Proof Stress	N/mm ²	450 min.
Elongation on 5D	%	15 min.
Impact Energy CV @ as-welded	Joules	-

Wire Dia (mm)

min.	0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
	-	-	-	-	80	80	80

Current Range (Amps)

max.	-	-	-	-	120	120	120
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Volt Range (Volts)

min.	-	-	-	-	-	-	-
max.	-	-	-	-	-	-	-

Packaging Information

Kg Per Tube

-	-	-	-	5	5	5
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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

