



WB410T T.I.G. WELDING WIRE

SPECIFICATIONS	AWS A5.9-81 : ER410									
PRODUCT DESCRIPTION	Solid TIG wire for the welding of matching alloy stainless steels.									
APPLICATION	Suitable for welding and repairing alloys such as 410 & 13%Cr steels.									
TYPICAL ALL-WELD METAL COMPOSITION(WEIGHT %)	C	Mn	Si	Cr	Ni	Mo	Cu			
	0.09 - 0.12	0.60 max.	0.25- 0.50	11.3- 13.5	0.60 max.	0.50 max.	0.75 max.			

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES	Ultimate Tensile Strength	N/mm ²	600
	Yield Stress/0.2% Proof Stress	N/mm ²	450
	Elongation on 4D	%	25
	Charpy Vee Impact @ PWHT	Joules	-

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		-	-	-	-	5.0	5.0	5.0

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

