



# WB625T T.I.G. WELDING WIRE

<b>Classifications</b>	ANSI/AWS A5.14 : ERNiCrMo-3    BS2901 Part 5 : Grade NA43										
<b>Product Description</b>	WB625T is a TIG wire for the welding nickel base alloys, overlaying carbon steels and combinations of the both.										
<b>Applications</b>	WB625T is extensively used in the offshore / marine industry. Excellent pitting resistance (PRE=50). Typical materials to be welded:-Alloy 625 : ASTM UNS N06625, BS NA21, DIN 2.4856, Inconel® 625 (Inco), Nicrofer 6020HMo, 6022hMo(VDM). High Nickel : Inconel ® 601, Incoloy ® 800H, 825 (Inco) and equivalents. Super Austenitic : UNS S31254, (254SMO), 904L and similar alloys. In addition to the above materials, WB625T is extensively used for overlaying carbon steels and combinations of the above. Suitable for welding and repairing of various grades of stainless steels and dissimilar combinations.										
<b>All-Weld Metal Composition (Weight %)</b>		Ni	C	Mn	Fe	S	Si	P	Cr	Al	Ti
	<b>min.</b>	58.0	-	-	-	-	-	-	20.0	-	-
	<b>max.</b>	-	0.10	0.50	5.0	0.015	0.50	0.02	23.0	0.40	0.40
		Nb	Mo	Co	Cu	Others					
	<b>min.</b>	3.15	8.0	-	-	-					
	<b>max.</b>	4.15	10.0	1.0	0.50	0.50					
<b>Typical All-Weld Metal, Batch, Mechanical Properties</b>	Ultimate Tensile Strength					MPa	808				
	0.2% Proof Stress					MPa	529				
	Elongation on 4D					%	40				
	Charpy Vee Impact @ -196°C as-welded					Joules	100				

<b>Wire Dia (mm)</b>		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>min.</b>	-	-	-	-	80	80	80
	<b>max.</b>	-	-	-	-	120	120	120
<b>Volt Range (Volts)</b>	<b>min.</b>	-	-	-	-	-	-	-
	<b>max.</b>	-	-	-	-	-	-	-
<b>Packaging Information</b>								
<b>Kg Per Tube</b>		-	-	-	-	5.0	5.0	5.0
<b>Storage</b>	<b>Storage</b> 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%.							
<b>Gases</b>	<b>Gas</b> Pure Argon <b>Flow Rate</b> 7-10 l/min							

## Current Conditions DC- and Welding Positions

