



WB6543 T.I.G. WELDING WIRE

Classifications AWS A5.28 : ER90S-B3

Product Description Copper coated 2¼% Chromium, 1% Molybdenum solid TIG wire.

Applications

WB6543 is suitable for welding 2¼%Cr - 1%Mo creep-resisting steels.

The balanced Manganese and Silicon ensures optimum deoxidisation and weld fluidity.

Typical material grades :- BS1501 Part 2 Grade 622, ASTM A387 D, BS1503 Grade 622, BS1504 Grade 622, BS3100 Grade B3, ASTM A217 WC9, BS1503 Grade 660, BS1504 Grade 660, BS3100 Grade B7.

Scaling and creep resistance to 600°C.

WB6543 conforms to National Power specification requirements.

Wire Composition(Weight %)

	C	Mn	Si	S	P	Cr	Ni	Mo	V	As
min.	0.08	0.80	0.50	-	-	2.20	-	0.90	-	-
max.	0.12	1.20	0.80	0.015	0.015	2.60	0.15	1.10	0.02	0.035

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm ²	620 min.
Yield Stress/0.2% Proof Stress	N/mm ²	540 min.
Elongation on 5D	%	17 min.
Impact Energy CV @ +20°C	Joules	47min.
Stress relieved @ 690°C / 1Hr		

Wire Dia (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
min.		-	-	-	-	80	80	80
Current Range (Amps)	max.	-	-	-	-	120	120	120
min.		-	-	-	-	-	-	-
Volt Range (Volts)	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

