



WB6544 T.I.G. WELDING WIRE

Classifications ~AWS A5.28 : ER80S-B6

Product Description Copper coated 5% Chromium / 0.5% Molybdenum solid TIG wire.

Applications

WB6544 (A34 type) is suitable for welding 5%Cr 0.5%Mo creep-resisting steels. Used mainly by the power engineering industry for headers, steam piping and turbine rotors.

Typical material grades :- ASTM A387 Gr.5, BS1503 Grade 625, ASTM A336 Grade F5, BS3604 Grades HFS 625 & CFS 625, ASTM A199 Grade T5 & A213 Grade T5.

WB6544 is used extensively for welding and repairing, heat exchangers, pressure vessels, piping and tubing.

Wire Composition(Weight %)

| | C | Mn | Si | S | P | Ni | Cr | Mo | Cu |
|-------------|------|------|------|-------|-------|------|-----|------|------|
| min. | 0.05 | 0.40 | 0.30 | - | - | - | 5.0 | 0.45 | - |
| max. | 0.12 | 0.90 | 0.90 | 0.020 | 0.020 | 0.15 | 6.0 | 0.65 | 0.20 |

Typical All-Weld Metal Mechanical Properties

| | | |
|------------------------------------|-------------------|----------|
| Ultimate Tensile Strength | N/mm ² | 550 min. |
| Yield Stress/0.2% Proof Stress | N/mm ² | 470 min. |
| Elongation on 4D | % | 17 min. |
| Impact Energy CV @ +20°C as-welded | Joules | 27 min. |

| 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 |
| 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

