



WB6546 T.I.G. WELDING WIRE

Classifications	AWS A5.28 : ER90S-B9 AWS A5.23 : EB9																										
Product Description	Copper coated, modified 9% Chromium / 1% Molybdenum / V / Nb solid TIG wire.																										
Applications	WB6546 is suitable for welding modified 9%Cr 1%Mo creep-resisting steels. Used mainly by the power engineering industry for headers, steam piping and turbine rotors. Typical material grades :- ASTM A213 T91, A387 Grade 91, A335 P91, A182, A336 F91. DIN X10CrMoVNb 9 1, 1.4903																										
Wire Composition(Weight %)	C	Mn	Si	S	P	Ni	Cr	Mo	Cu	V	N																
min.	0.08	0.35	0.20	-	-	0.40	8.0	0.9	-	0.18	0.03																
max.	0.12	1.00	0.45	0.010	0.020	0.80	9.5	1.1	0.30	0.25	0.07																
Typical All-Weld Metal Mechanical Properties	<table border="0"> <tr> <td>Ultimate Tensile Strength</td> <td>N/mm²</td> <td>800</td> </tr> <tr> <td>Yield Stress/0.2% Proof Stress</td> <td>N/mm²</td> <td>700</td> </tr> <tr> <td>Elongation on 4D</td> <td>%</td> <td>19</td> </tr> <tr> <td>Impact Energy CV @ +20°C</td> <td>Joules</td> <td>220</td> </tr> <tr> <td>PWHT @ 760°C/2 hrs</td> <td></td> <td></td> </tr> </table>												Ultimate Tensile Strength	N/mm ²	800	Yield Stress/0.2% Proof Stress	N/mm ²	700	Elongation on 4D	%	19	Impact Energy CV @ +20°C	Joules	220	PWHT @ 760°C/2 hrs		
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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	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

