



WB82T T.I.G. WELDING WIRE

Classifications	AWS A5.14 : ERNiCr-3										
Product Description	WB82T is a TIG wire for the welding nickel base alloys, and dissimilar material combinations.										
Applications	WB82T is extensively used in the offshore / marine industry. Excellent pitting resistance. Typical materials to be welded:- High Nickel : Inconel ®, 600, 601, 690, Incoloy ® 800, 800H, 825 (Inco) and equivalents.										
All-Weld Metal Composition (Weight %)		C	Mn	Ni	Si	S	P	Nb	Fe	Cr	Cu
	min.	-	2.5	67.0	-	-	-	2.0	-	18.0	-
	max.	0.05	3.5	-	0.50	0.015	0.015	3.0	3.0	22.0	0.50
	min.	Ti									
	max.	-									
		0.75									
TYPICAL ALL WELD METAL MECHANICAL PROPERTIES	Ultimate Tensile Strength		N/mm ²		630 min.						
	Yield Stress/0.2% Proof Stress		N/mm ²		380 min.						
	Elongation on 4D		%		30 min.						
	Charpy Vee Impact @ -196°C		Joules		70 min.						

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

