WBC276T T.I.G. WELDING WIRE

Classifications	AWS A5.14 : ERNiCrMo-4
Product Description	WBC276T is a TIG wire for the welding nickel base alloys (HAS C-276)+6, overlaying carbon steels and combinations of the both.
Applications	WBC276T is extensively used in the offshore / marine industry. Excellent pitting resistance (PRE=50). Typical materials to be welded:- ASTM B524, B575. Also 6%Mo super austenitics. In addition to the above materials, WBC276T 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.

All-Weld Metal Composition (Weight %)

	Ni	C	Mn	Fe	S	Si	P	Cr	W	V
min.	Bal.	-	-	4.0	-	-	-	14.5	3.0	-
max.	-	0.02	1.0	7.0	0.03	0.08	0.04	16.5	4.5	0.35

	Mo
min.	15.0
max.	17.0

Typical All-Weld Metal, Batch, Mechanical Properties

Ultimate Tensile Strength	MPa	700 min.
0.2% Proof Stress	MPa	400 min.
Elongation on 5D	%	30
Charpy Vee Impact @ as-welded	Joules	-

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