



WB617T TIG WELDING WIRE

Classifications	AWS A5.14: ERNiCoMo-1 BS EN ISO 18274-A: NiCr22Co12Mo9										
PRODUCT DESCRIPTION	WB617T is TIG wire for the welding nickel base alloys, and dissimilar material combinations.										
APPLICATION	Used mainly for welding and repairing nickel base alloys such as Inconel 617©, Nicrofer 5520Co, Inconel 601®. Also used for dissimilar weld with above and the following materials: HK40, CR32W, CR39W and HP40Cb. Used extensively in the power generation / petro-chemical industries										
All-Weld Metal Composition (Wt. %)		C	Mn	Si	S	P	Ni	Cr	Cu	Nb	Fe
	min.	0.05	0.5	0.40	-	-	50	22.0	-	-	-
	max.	0.10	1.0	0.75	0.015	0.030	-	26.0	0.50	1.0	3.0
		Co									
	min.	10.0									
	max.	14.0									
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		700						
	Yield Stress/0.2% Proof Stress		N/mm ²		400						
	Elongation on 4D		%		25						
	Impact Energy CV @ +20°C		Joules		90						
	As welded										

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	-	-	60	80	100
	max.	-	-	-	-	120	160	200
Volt Range (Volts)	min.	-	-	-	-	8	8	8
	max.	-	-	-	-	14	14	14
Packaging Information								
Kg Per Reel		-	-	-	-	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 Helium, Pure Argon or Argon + Helium mixture Flow Rate 12-14 l/min							

Current Conditions DC- and Welding Positions

