



WB625M MIG WELDING WIRE

Classifications	AWS A5.14: ERNiCrMo-3 BS EN ISO 18274: NiCr22Mo9Nb									
Product Description	WB625M is MIG wire for the welding nickel base alloys, overlaying carbon steels and combinations of both.									
Applications	WB625M is extensively used in the offshore / marine industry. Excellent pitting resistance (PRE=50). Typical materials to be welded: Alloy 625: ASTM UNS N06625, BS NA21, DIN 2.4856, Inconel® 625 (Inco), Nicrofer 6020hMo, 6022Hmo (VDM), High Nickel : Inconel ® 601, Incoloy ® 800H, 825 (Inco) and equivalents, Super Austenitic : UNS S31254, (254SMO), 904L and similar alloys. In addition to the above materials, WB625M 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 (Wt. %)	C	Mn	Ni	Si	S	P	Nb+Ta	Fe	Mo	Cu
min.	-	-	58	-	-	-	3.15	-	8.0	-
max.	0.10	0.50	-	0.50	0.015	0.020	4.15	5.0	10.0	0.50
	Al	Ti	Co	Cr	Other					
min.	-	-	-	20.0	-					
max.	0.40	0.40	-	23.0	0.50					
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength				N/mm ²		792			
	Yield Stress/0.2% Proof Stress				N/mm ²		529			
	Elongation on 4D				%		38			
	Impact Energy CV @ -196°C				Joules		80			
	As welded						*Actual			

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	60	75	130	-	-	-
	max.	-	170	250	300	-	-	-
Volt Range (Volts)	min.	-	18	18	18	-	-	-
	max.	-	26	28	28	-	-	-
Packaging Information Kg Per Reel		-	0.7/15	15	15	-	-	-
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 100% Argon or 98% Argon / 1% Oxygen			Flow Rate 15-20 L/min			

Current Conditions DC- and Welding Positions

