WB800H TIG WELDING WIRE

Classifications	**BS EN ISO 14343-A:** W Z 21 33 Mn Nb
Product Description	Micro-alloyed 21%Cr-33%Ni-1%Nb TIG wire for welding matching Alloy 800 heat resistant alloys.
Applications	This wire is used for welding any of the standard grades of base material UNS N08800, N08810 and N08811. These alloys have good resistance to thermal fatigue, thermal shock, corrosion and ageing embrittlement at service temperatures up to ~1000ºC. Typically used in the petrochemical, furnace and Nuclear industries.

Wire Composition (Wt. %)

	C	Mn	Si	Cr	Ni	Nb	Ti	Al	Fe
Typical	- 0.15	- 4.7	- 0.2	- 21.5	- 32.5	- 1.2	- 0.2	- 0.15	- Bal.

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm²	600 min.
Yield Stress/0.2% Proof Stress	N/mm²	400 min.
Elongation on 5D	%	25 min.

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	**min.**	-	-	-	-	60	70	80
	max.	-	-	-	-	120	180	220
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	**Flow Rate**
Pure Argon	12-14 L/min

Current Conditions DC- and Welding Positions