



WB82M MIG WELDING WIRE

Classifications	AWS A5.14: ERNiCr-3 BS EN ISO 18274: NiCr20Mn3Nb									
Product Description	WB82M is MIG wire for the welding nickel base alloys, dissimilar joints, corrosion, and high temperature applications.									
Applications	WB82M is extensively used in the offshore / marine / power generation. Typical materials to be welded: - Inconel Alloys 600, 601 & 690, Incoloy alloys 800 & 800HT and for Incoloy alloy 330. Incolloys, Nilo, Brghtray and similar Ni-base alloys. Dissimilar joints between Ni-base alloys, ferritic and austenitic steels.									
All-Weld Metal Composition (Wt. %)	C	Mn	Ni	Si	S	P	Nb	Fe	Cu	Ti
	min. - max. 0.05	2.5 3.5	67.0 -	- 0.50	- 0.015	- 0.015	2.0 3.0	- 3.0	- 0.50	- 0.75
	Cr									
	min. 18.0 max. 22.0									
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		640					
	Yield Stress/0.2% Proof Stress		N/mm ²		360					
	Elongation on 4D		%		40					
	Impact Energy CV @ -196°C		Joules		>100					
	As welded									

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	200	250	-	-	-
Volt Range (Volts)	min.	-	18	18	18	-	-	-
	max.	-	26	28	28	-	-	-
Packaging Information Kg Per Reel		-	13.6	13.6	13.6	-	-	-
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, Ar/He or 98% Argon / 2% Oxygen				Flow Rate 15-20 L/min			

Current Conditions DC+ and Welding Positions

