



# WB67T TIG WELDING WIRE

<b>Classifications</b>	<b>AWS A5.7: ERcUNi      BS EN ISO 24373: SCu 7158</b>										
<b>Product Description</b>	Copper-Nickel, solid TIG wire.										
<b>Applications</b>	<p>WB67T is suitable for the repair and welding of CN103-CN107, CA 715UNS C71500 and similar cupronickel alloys.</p> <p>Used extensively for offshore pipe and cladding systems, desalination plants and similar applications / environments.</p>										
<b>Wire Composition (Wt. %)</b>											
<b>min.</b>	Cu bal.	Ni 29.0	Mn -	Ti 0.20	Al -	Fe 0.40	Si -	Pb -	P -	S -	
<b>max.</b>	-	32.0	1.0	0.50	0.03	0.70	0.25	0.02	0.02	0.01	
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength					N/mm <sup>2</sup>	345 Min.				
	Yield Stress/0.2% Proof Stress					N/mm <sup>2</sup>	-				
	Elongation on 5D					%	-				
	Impact Energy CV @					Joules	-				
	As welded										
	Hardness Value					HV	64 - 94				

<b>Wire Dia. (mm)</b>		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>min.</b>	-	-	-	-	60	80	100
	<b>max.</b>	-	-	-	-	160	200	250
<b>Volt Range (Volts)</b>	<b>min.</b>	-	-	-	-	-	-	-
	<b>max.</b>	-	-	-	-	-	-	-
<b>Packaging Information</b>								
<b>Kg Per Tube</b>		-	-	-	-	5	5	5
<b>Storage</b>	<b>Storage</b> 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%.							
<b>Gases</b>	<b>Gas</b> 100% Argon or 95% Argon / 5% H <sub>2</sub>							
	<b>Flow Rate</b> 12-14 L/min							

## Current Conditions DC- and Welding Positions

