

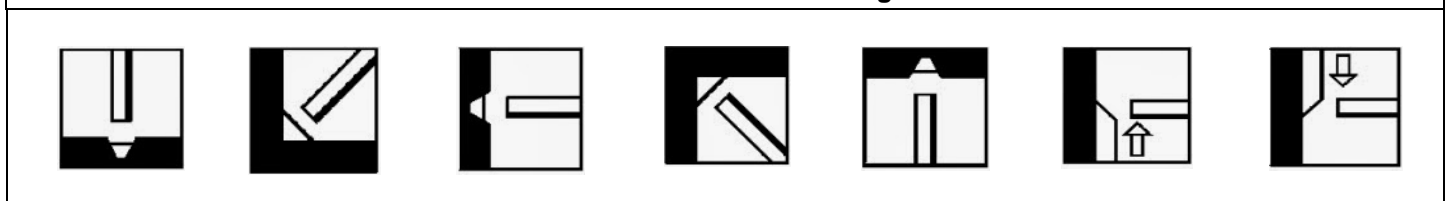


WB316LT TIG WELDING WIRE

Classifications	AWS A5.9: ER 316L BS EN ISO 14343-A: W 19 12 3 L									
Product Description	316L stainless steel TIG wire.									
Applications	WB316LT is used mainly for welding and repairing 316L stainless steels and wrought and cast alloys 316, S62, CF3M, CF8M and 316C12 it is also suitable for the mixed welding of 304L, 316L, 321 and 347 stainless steels. Ferrite in the 3-10FN range. Corrosion resistant up to 400°C.									
Wire Composition (Wt. %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu
min.		-	1.0	0.25	-	-	18.0	11.0	2.0	-
max.		0.03	2.5	0.65	0.03	0.03	20.0	14.0	3.0	0.50
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		510 min.					
	Yield Stress/0.2% Proof Stress		N/mm ²		320 min.					
	Elongation on 5D		%		25 min.					
	Impact Energy CV @ -196°C		Joules		34J Min (50J Typical)					
	As welded									

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 Pure Argon				Flow Rate 12-14 L/min			

Current Conditions DC- and Welding Positions



Approvals: CE