



WB6546 TIG WELDING WIRE

Classifications	AWS A5.28: ER80S-B8																										
Product Description	Copper coated, modified 9% Chromium / 1% Molybdenum / V / Nb solid TIG wire.																										
Applications	<p>WB6546 is suitable for welding modified 9%Cr 1%Mo creep-resisting steels. Used mainly by the power engineering industry for headers, steam piping and turbine rotors.</p> <p>Typical material grades :- ASTM A213 T91, A387 Grade 91, A335 P91, A182, A336 F91. DIN X10CrMoVNb 9 1, 1.4903</p>																										
Wire Composition (Wt. %)	C	Mn	Si	S	P	Ni	Cr	Mo	Cu	V	N																
min.	0.08	0.35	0.20	-	-	0.40	8.0	0.9	-	0.18	0.03																
max.	0.12	1.00	0.45	0.010	0.020	0.80	9.5	1.1	0.30	0.25	0.07																
Typical All-Weld Metal Mechanical Properties	<table> <tr> <td>Ultimate Tensile Strength</td> <td>N/mm²</td> <td>750</td> </tr> <tr> <td>Yield Stress/0.2% Proof Stress</td> <td>N/mm²</td> <td>600</td> </tr> <tr> <td>Elongation on 4D</td> <td>%</td> <td>25</td> </tr> <tr> <td>Impact Energy CV @ +20°C</td> <td>Joules</td> <td>220</td> </tr> <tr> <td>PWHT @ 760°C/2 hrs</td> <td></td> <td></td> </tr> </table>												Ultimate Tensile Strength	N/mm ²	750	Yield Stress/0.2% Proof Stress	N/mm ²	600	Elongation on 4D	%	25	Impact Energy CV @ +20°C	Joules	220	PWHT @ 760°C/2 hrs		
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Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	-	-	60	80	100
	max.	-	-	-	-	120	160	200
Volt Range (Volts)	min.	-	-	-	-	-	-	-
	max.	-	-	-	-	-	-	-
Packaging Information								
Kg Per Tube		-	-	-	-	5	5	5
Storage	<p>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%.</p>							
Gases	<p>Gas Pure Argon</p> <p>Flow Rate 12-14 L/min</p>							

Current Conditions DC- and Welding Positions

