



WB61T TIG WELDING WIRE

Classification	AWS A5.14: ERNi-1									
Product Description	WB61T is a TIG wire for the welding of nickel base alloys.									
Application	WB61T is extensively used for the welding and repairing of heat exchangers, piping vessels and evaporators. Also, a popular choice within the chemical process industry. Typical base materials: Monel alloys, Incoloy alloys, Nickel 200 & 201.									
Wire Composition (Wt. %)	C	Mn	Si	S	Ni	Fe	Cu	Al	Mo	Ti
Typical.	-	-	-	-	93.0	-	-	-	-	3.00
max.	0.15	1.00	0.75	0.015	-	1.00	0.25	1.5	-	3.50

Typical all weld metal mechanical properties	Ultimate Tensile Strength	N/mm ²	414
	Yield Stress/0.2% Proof Stress	N/mm ²	280
	Elongation on 4D	%	25
	Charpy V Impact @ -30°C	Joules	120
	@ -196°C	Joules	100

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.	-	-	-	-	100	140	160
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

