WB90/10CuNi TIG WELDING WIRE

Classifications	**AWS A5.7:** ERCuNi10Fe
Product Description	Copper-Nickel, solid TIG wire with typically 86% Cu and 10.5% Ni.
Applications	WB67T is suitable for the repair and welding of C70600, C96200, Cunifer 10 and similar cupronickel alloys. Used extensively for offshore pipe and cladding systems, desalination plants and similar applications / environments.

Wire Composition (Wt. %)

	Cu	Ni	Mn	Ti	C	Fe	Si	Pb	P	S
min.	bal.	9.0	0.5	0.1	-	0.5	-	-	-	-
max.	-	11.0	1.5	0.5	0.5	2.0	0.2	0.02	0.02	0.02

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm²	>300
Yield Stress/0.2% Proof Stress	N/mm²	>180
Elongation on 5D	%	>32
Impact Energy CV @	Joules	-
Hardness	>80 HV	

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	150	180
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

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