WBNiCu-7T TIG WELDING WIRE

Classifications	**AWS A5.14**: ERNiCu-7. ASME SFA 5.14
Product Description	Solid wire for TIG welding Ni/Cu alloys.
Applications	WBNiCu-7T wire is suitable for welding material of similar composition to itself and others in the Ni-Cu/Cu-Ni families to Nickel 200. Typical materials to be welded:-, ASTM B127, B163, B164, B165. BS NA13, NA1 (cast), UNS N04405, N05500, A404 M35-1, M30C (cast), DIN 2.4360, 2.4361, 2.4365 (cast), Proprietary Inco Monel 400, R405, K500, VDM Nicorros.

Wire Composition (Wt. %)

	C	Mn	Si	S	P	Ni	Ti	Al	Fe	Cu
min.	-	1.0	0.30	-	-	62.0	1.5	-	0.5	27.0
max.	0.15	4.0	1.25	0.015	0.020	69.0	3.0	1.25	2.5	34.0

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm²	536 min.
Yield Stress/0.2% Proof Stress	N/mm²	300 min.
Elongation on 5D	%	42 min.
Impact Energy CV @ -30°C	Joules	>90

Wire Diameter (mm)		1.6mm	2.4mm	3.2mm				
Current Range (Amps)	**Min.**	60	70	90				
	Max.	100	140	180				
Packaging Information		1000mm	1000mm	1000mm				
Kg Per Packet		5kgs	5kgs	5kgs				

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 or 75%Ar/25%He

Flow Rate
12-14 L/min

Current Conditions DC- and Welding Positions