



## WB67T TIG WELDING WIRE

|   |   |         |        |         |      |                   |      |       |      |      |  |
|---|---|---------|--------|---------|------|-------------------|------|-------|------|------|--|
| <b>Classifications</b>                              | AWS A5.7: ERCuNi  |         |        |         |      |                   |      |       |      |      |  |
| <b>Product Description</b>                          | Copper-Nickel, solid TIG wire.  |         |        |         |      |                   |      |       |      |      |  |
| <b>Applications</b>                                 | <p>WB67T is suitable for the repair and welding of CN103-CN107, CA 715UNS C71500 and similar cupronickel alloys.</p> <p>Used extensively for offshore pipe and cladding systems, desalination plants and similar applications / environments.</p> |         |        |         |      |                   |      |       |      |      |  |
| <b>Wire Composition (Wt. %)</b>                     |   |         |        |         |      |                   |      |       |      |      |  |
| <b>min.</b>   | Cu bal.   | Ni 30.0 | Mn 0.5 | Ti 0.20 | Al - | Fe 0.40           | Si - | Pb -  | P -  | S -  |  |
| <b>max.</b>   | -   | 32.0    | 1.0    | 0.50    | 0.03 | 0.75              | 0.1  | 0.007 | 0.01 | 0.01 |  |
| <b>Typical All-Weld Metal Mechanical Properties</b> | Ultimate Tensile Strength   |         |        |         |      | N/mm <sup>2</sup> |      | -     |      |      |  |
|   | Yield Stress/0.2% Proof Stress  |         |        |         |      | N/mm <sup>2</sup> |      | -     |      |      |  |
|   | Elongation on 5D  |         |        |         |      | %                 |      | -     |      |      |  |
|   | Impact Energy CV @ As welded  |         |        |         |      | Joules            |      | -     |      |      |  |

|                              |   |       |       |       |       |       |       |       |
|------------------------------|---|-------|-------|-------|-------|-------|-------|-------|
| <b>Wire Dia. (mm)</b>        |   | 0.6mm | 0.8mm | 1.0mm | 1.2mm | 1.6mm | 2.4mm | 3.2mm |
| <b>Current Range (Amps)</b>  | <b>min.</b>   | -     | -     | -     | -     | 60    | 80    | 100   |
|                              | <b>max.</b>   | -     | -     | -     | -     | 120   | 150   | 180   |
| <b>Volt Range (Volts)</b>    | <b>min.</b>   | -     | -     | -     | -     | -     | -     | -     |
|                              | <b>max.</b>   | -     | -     | -     | -     | -     | -     | -     |
| <b>Packaging Information</b> |   |       |       |       |       |       |       |       |
| <b>Kg Per Tube</b>           |   | -     | -     | -     | -     | 5     | 5     | 5     |
| <b>Storage</b>               | <b>Storage</b><br>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%. |       |       |       |       |       |       |       |
| <b>Gases</b>                 | <b>Gas</b><br>Pure Argon<br><br><b>Flow Rate</b><br>12-14 L/min   |       |       |       |       |       |       |       |

### Current Conditions DC- and Welding Positions

