



WB6545 TIG WELDING WIRE

Classifications	AWS A5.28: ER80S-B8 BS EN ISO 21952-A: W CrMo9Si									
Product Description	Copper coated 9% Chromium / 1% Molybdenum solid TIG wire.									
Applications	WB6545 is suitable for welding 9%Cr 1%Mo creep-resisting steels. Used mainly by the power engineering industry for headers, steam piping and turbine rotors. Typical material grades :- ASTM A336 Grade F9, ASTM A217 C12, BS1504 Grade 629 and BS3100 Grades 629/470. DIN G-X 12CrMo 10 1, ASTM A335 Grades P9.									
Wire Composition (Wt. %)	C	Mn	Si	S	P	Ni	Cr	Mo	Cu	
min.	-	0.40	0.40	-	-	-	8.00	0.80	-	
max.	0.10	0.70	0.70	0.025	0.025	0.50	10.50	1.20	0.35	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		550 min.					
	Yield Stress/0.2% Proof Stress		N/mm ²		470 min.					
	Elongation on 4D		%		17 min.					
	Impact Energy CV @ +20°C		Joules		47 min.					
	PWHT @ 745°C/2 hrs									

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.	-	-	-	-	180	200	240
Volt Range (Volts)	min.	-	-	-	-	-	-	-
	max.	-	-	-	-	-	-	-
Packaging Information								
Kg Per Tube		-	-	-	-	5.0	5.0	5.0
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

