



## WB82T SC TIG WELDING WIRE

<b>Classifications</b>	<b>AWS A5.14: ERNiCr-3</b>										
<b>Product Description</b>	WB82T SC is a nuclear grade, super clean TIG wire for the welding nickel base alloys, and dissimilar material combinations.										
<b>Applications</b>	WB82T SC is extensively used in the offshore / marine industry. Excellent pitting resistance. Typical materials to be welded:- High Nickel : Inconel ®, 600, 601, 690, Incoloy ® 800, 800H, 825 (Inco) and equivalents.										
<b>All-Weld Metal Composition (Weight %)</b>		C	Mn	Ni	Si	S	P	Nb	Fe	Cr	Cu
	<b>min.</b>	-	2.5	67.0	-	-	-	2.0	-	18.0	-
	<b>max.</b>	0.05	3.5	-	0.50	0.015	0.015	3.0	3.0	22.0	0.50
	<b>min.</b>	Ti									
	<b>max.</b>	-									
		0.75									
<b>TYPICAL ALL WELD METAL MECHANICAL PROPERTIES</b>		Ultimate Tensile Strength		N/mm <sup>2</sup>		630 min.					
		Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>		380 min.					
		Elongation on 4D		%		30 min.					
		Charpy Vee Impact @ -196°C		Joules		70 min.					

<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>	-	-	-	80	80	80	80
	<b>max.</b>	-	-	-	120	120	120	120
<b>Volt Range (Volts)</b>	<b>min.</b>	-	-	-	-	-	-	-
	<b>max.</b>	-	-	-	-	-	-	-
<b>Packaging Information</b>								
<b>Kg Per Tube</b>		-	-	-	1.25/5.0	2.0/5.0	5.0	5.0
<b>Storage</b>	<b>Storage</b> 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> Pure Argon  <b>Flow Rate</b> 12-14 L/min							

### Current Conditions DC- and Welding Positions

