



WB625T TIG WELDING WIRE

Classifications	AWS A5.14/A5.14M: ERNiCrMo-3 BS EN ISO 18274: NiCr22Mo9Nb										
Product Description	WB625T is a TIG wire for the welding nickel base alloys, overlaying carbon steels and combinations of both.										
Applications	WB625T is extensively used in the offshore / marine industry. Excellent pitting resistance (PRE=50). Typical materials to be welded: Alloy 625: ASTM UNS N06625, BS NA21, DIN 2.4856, Inconel® 625 (Inco), Nicrofer 6020HMo, 6022hMo (VDM). High Nickel: Inconel® 601, Incoloy® 800H, 825 (Inco) and equivalents. Super Austenitic: UNS S31254, (254SMO), 904L and similar alloys. In addition to the above materials, WB625T is extensively used for overlaying carbon steels and combinations of the above. Suitable for welding and repairing of various grades of stainless steels and dissimilar combinations.										
All-Weld Metal Composition (Weight %)		Ni	C	Mn	Fe	S	Si	P	Cr	Al	Ti
	min.	58.0	-	-	-	-	-	-	20.0	-	-
	max.	-	0.10	0.50	0.5	0.015	0.50	0.02	23.0	0.40	0.40
		Nb	Mo	Co	Cu	Others					
	min.	3.15	8.0	-	-	-					
	max.	4.15	10.0	1.0	0.50	0.50					
Typical All-Weld Metal, Batch, Mechanical Properties	Ultimate Tensile Strength					MPa	829				
	0.2% Proof Stress					MPa	548				
	Elongation on 4D					%	40				
	Charpy Vee Impact @ -196°C					Joules	100				
	As welded										

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	-	-	70	80	80
	max.	-	-	-	-	120	160	200
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

