



## WB61M MIG WELDING WIRE

<b>Classification</b>	<b>AWS A5.14: ERNi-1</b>									
<b>Product Description</b>	Solid MIG wire for the welding of nickel base alloys.									
<b>Application</b>	WB61M is extensively used for the welding and repairing of heat exchangers, piping vessels and evaporators. Also, a popular choice within the chemical process industry.  Typical base materials: Monel alloys, Incoloy alloys, Nickel 200 & 201.									
<b>Wire Composition (Wt. %)</b>	C	Mn	Si	S	Ni	Fe	Cu	Al	Mo	Ti
<b>Typical.</b>	-	-	-	-	93.0	-	-	-	-	3.00
<b>max.</b>	0.15	1.00	0.75	0.015	-	1.00	0.25	1.5	-	3.50

<b>Typical all weld metal mechanical properties</b>	Ultimate Tensile Strength	N/mm <sup>2</sup>	414
	Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	280
	Elongation on 4D	%	25
	Charpy V Impact @ -30°C	Joules	120
	@ -196°C	Joules	100

<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>	-	-	-	150	-	-	-
	<b>max.</b>	-	-	-	250	-	-	-
<b>Volt Range (Volts)</b>	<b>min.</b>	-	-	-	20	-	-	-
	<b>max.</b>	-	-	-	28	-	-	-
<b>Packaging Information</b>								
<b>Kg Per Tube</b>		-	-	-	15	-	-	-
<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 or Ar/He mix  <b>Flow Rate</b> 15-20 L/min							

### Current Conditions DC- and Welding Positions

