



## WB6545 TIG WELDING WIRE

<b>Classifications</b>	<b>AWS A5.28:</b> ER90S-B9	<b>BS EN ISO 21952-A:</b> W CrMo91								
<b>Product Description</b>	Copper coated 9% Chromium / 1% Molybdenum solid TIG wire.									
<b>Applications</b>	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.									
<b>Wire Composition (Wt. %)</b>	C	Mn	Si	S	P	Ni	Cr	Mo	Cu	
<b>min.</b>	0.05	0.40	0.20	-	-	-	8.0	0.8	-	
<b>max.</b>	0.16	0.60	0.50	0.020	0.020	0.5	10.5	1.2	0.30	
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength		N/mm <sup>2</sup>		750	*720				
	Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>		600	*585				
	Elongation on 4D		%		27	*25				
	Impact Energy CV @ +20°C		Joules		120	*115				
	As welded									
	PWHT @ 760°C/2 hrs*									

<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	160	200
<b>Volt Range (Volts)</b>	<b>min.</b>	-	-	-	-	-	-	-
	<b>max.</b>	-	-	-	-	-	-	-
<b>Packaging Information</b>								
<b>Kg Per Tube</b>		-	-	-	-	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

