



WB59T TIG WELDING WIRE

Classifications	AWS A5.14: ERNiCrMo-13										
Product Description	WB59T is TIG wire for the welding Ni-Cr-Mo base alloys.										
Applications	<p>WB59T is extensively used in the offshore / marine industry. Excellent pitting resistance.</p> <p>Typical materials to be welded: Alloy 625, C-276, C22, and other high strength alloys such as 6Mo stainless.</p> <p>Some typical base metals that this alloy is used on are ASTM and ASME B an SB 574, 575, 619, 625 & 625.</p>										
All-Weld Metal Composition (Wt. %)	min.	C	Mn	Ni Bal.	Si	S	P	Co	Fe	Mo	Cu
	max.	0.01	0.50	-	0.10	0.01	0.01	0.3	1.5	15.0 16.5	- 0.50
	min.	Al	Ti	Cr							
	max.	0.1 0.4	- 0.40	22.0 24.0							
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		700 min.						
	Yield Stress/0.2% Proof Stress		N/mm ²		400 min.						
	Elongation on 4D		%		30 min.						
	Impact Energy CV @ -196°C		Joules		70 min.						
	As welded										

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.	-	-	-	-	120	180	220
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				Flow Rate			
	Pure Argon				12-14 L/min			

Current Conditions DC- and Welding Positions

