



WB800H

TIG WELDING WIRE

Classifications	BS EN ISO 14343-A: W Z 21 33 Mn Nb									
Product Description	Micro-alloyed 21%Cr-33%Ni-1%Nb TIG wire for welding matching Alloy 800 heat resistant alloys									
Applications	<p>This wire is used for welding any of the standard grades of base material UNS N08800, N08810 and N08811. These alloys have good resistance to thermal fatigue, thermal shock, corrosion and ageing embrittlement at service temperatures up to ~1,000°C.</p> <p>Typically used in the petrochemical, furnace and Nuclear industries.</p>									
Composition (Wt. %)	C	Mn	Si	Cr	Ni	Nb	Ti	Al	Fe	
Typical	0.15	4.7	0.2	21.5	32.5	1.2	0.2	0.15	Bal.	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength				N/mm ²		600 min.			
	Yield Stress/0.2% Proof Stress				N/mm ²		400 min.			
	Elongation on 5D				%		25 min.			

Wire Diameter (mm)	0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm	
Current Range (Amps)	Min.	-	-	-	-	60	70	80
	Max.	-	-	-	-	120	180	220
Volt Range (Volts)	Min.	-	-	-	-	-	-	-
	Max.	-	-	-	-	-	-	-
Packaging Information KG per Tube	-	-	-	-	5	5	5	
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

