

WA TOP ZONE-G

CLASSIFICATION

(AWS A 5.14 / ASMW II C SFA 5.14)*

*there is no classification system available for nickel base tubular wires.

DESCRIPTION

- Tubular nickel wire for gas shielded metal arc welding.
- Designed for top zone rolls located immediately below the copper mould or for other rolls in upper segment subjected to high temperature and extreme corrosion
- Micro alloyed solid strengthened nickel base alloy to enhance high temperature and corrosion properties.

APPLICATIONS

- WA TOP ZONE-G wire is specially designed for cladding of foot rolls and other rolls in upper segment to extend their life.

CONDITIONS OF USE

Current type	Gas flow rate	Stick out	Recovery
DC (+)	20-25 l/min.	20-25mm	98%

SHIELDING GAS: pure argon

OPERATING CONDITIONS

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]		Gas flow [l/min.]
	Range	Optimum	Range	Optimum	Optimum	Range	
1.6	200 - 300	250	24 - 28	26	20 - 25	20	20 - 25
2.0	300 - 400	350	24 - 28	26	20 - 25	25	20 - 25

WELDING POSITIONS

WA TOP ZONE-G tubular wire is suitable for all positional welding by adopting transfer mode and welding parameters

STANDARD DIAMETERS (mm)

1.6, 2.0

Other diameters: please consult us

PACKAGING

Diameter	2.4 mm
Standard packaging	Spool EN759: BS 300

Weight	Diameter	15 kg	2.4 mm
--------	----------	-------	--------