



## TUNGSTEN ELECTRODES

Welding high quality materials represents a challenge to the experienced welder and to welding technology. The fulfillment of quality requirements depends of the precise matching of material, manufacturing and design parameters. The safety of the structural component itself depends on a high welding quality and reproducible welding parameters.

The choice of the right electrode plays a decisive role in determining the form of the arc during TIG and Plasma welding.

Consistency of striking, arc stability, low electrode consumption and thus the quality of the welding process depend to a large extent on this choice. Only the TIG welder with his experience and expert knowledge can make the right choice.

### The choice is yours

Wolfram's range of products covers all internationally standardised tungsten electrodes in respect of chemical composition and dimensions.

Apart from these standardised TIG electrodes we can also supply Wolfram own developments with their high-grade welding properties, as i.e. the **WITSTAR®** or the **latest product ORBISTAR®** the tungsten electrode for orbital welding.



Code	Oxide additives Wt.%	Colour code	Standard
WP		green	DIN / EN 26 848
WT 10	0,90 .. 1,20 ThO <sub>2</sub>	yellow	
WT 20	1,80 .. 2,20 ThO <sub>2</sub>	red	
WT 30	2,80 .. 3,20 ThO <sub>2</sub>	purple	
WT 40	3,80 .. 4,20 ThO <sub>2</sub>	orange	
WZ 8	0,70 .. 0,90 ZrO <sub>2</sub>	white	
WC 20	1,80 .. 2,20 CeO <sub>2</sub>	grey	
WL 10	0,90 .. 1,20 LaO <sub>2</sub>	black	
WL 15 GOLDSTAR® (EWLa-1.5)	1,30 .. 1,70 LaO <sub>2</sub>	gold	ANSI/AWS 5.12
WL 20 WITSTAR®	1,80 .. 2,20 La <sub>2</sub> O <sub>3</sub>	blue	WOLFRAM INDUSTRIE®
WS 2 WITSTAR®	rare earth	turquoise	

Electrodes are also available according to American standard ANSI/AWS 5.12. Colour code however is different to DIN/EN 26 848

Diameter in mm			Length in mm
0,5 ± 0,05	3,0 ± 0,1	6,0 ± 0,1	50 ---- 75 ----- 150 ----- 175 -----
1,0 ± 0,05	3,2 ± 0,1	6,4 ± 0,1	
1,6 ± 0,05	4,0 ± 0,1	8,0 ± 0,1	
2,0 ± 0,05	4,8 ± 0,1	10,0 ± 0,1	
2,4 ± 0,05	5,0 ± 0,1	12,0 ± 0,1	

Other dimensions on request