



Wholesale Welding Supplies Ltd

PRODUCT INFORMATION SHEET



TIG WELDING ACCESSORIES

PART NUMBERS

HP16105
HP16108
HP16110
HP16112
HP16116
HP16124
HP16132
HP16140
HP16148
HP16155
HP16164

PRODUCT DESCRIPTIONS

2% THORIATED TUNGSTENS

0.5MM x 150MM
0.8MM x 150MM
1.0MM x 150MM
1.2MM x 150MM
1.6MM x 150MM
2.4MM x 150MM
3.2MM x 150MM
4.0MM x 150MM
4.8MM x 150MM
5.5MM x 150MM
6.4MM x 150MM

PICTURE FILE: HP16105-HP16164

PRODUCT DESCRIPTION:

The thoriated tungstens in this range contain 2% of thoria of thorium oxide (ThO_2) and are identified by a red colour code. The welding characteristics of 2% thoriated tungstens make them ideally suited to negative DC TIG welding of nickel alloys and mild and stainless steels, because they have an extended usable life and higher current-carrying capacity, due to the thoria addition. Thoriated tungstens carry approximately 20% more current than pure tungsten.

Thoriated tungstens also have reduced tip temperatures and tip wear rates, compared to pure tungstens when welding and provide greater resistance to contamination of the weld. Arc starting is easier and a negative DC arc is more stable with a thoriated tungsten than with a pure or zirconiated tungsten.

150mm length 2% thoriated tungstens are available from WWS in diameters ranging from 0.5mm to 6.4mm.

TECHNICAL SPECIFICATIONS:

Classification:	EWTh-2 (under ANSI/AWS A5.12-92)
Suitable Current:	DC (-) [negative DC]
Suitable For Welding:	Mild steel, Stainless steel and Nickel alloys
Tungsten Rod Length:	150mm
Available In Diameters:	0.5mm, 0.8mm, 1.0mm, 1.2mm, 1.6mm, 2.4mm, 3.2mm, 4.0mm and 4.8mm, 5.5mm, 6.4mm

NOTES:

A range of 1% thoriated tungstens (EWTh-1), suitable for DC (-) TIG welding of mild steel is also available, WWS part numbers HP16008 – HP16048.

WWS also supply a range of 0.8% zirconiated tungstens (EWZr-08), suitable for AC TIG welding of aluminium and magnesium alloys, WWS part numbers HP16208 – HP16240.

In addition, a range of 2% ceriated tungstens (EWCe-2), suitable for AC (e.g. for aluminium) and DC (-) (e.g. for mild steel and stainless steel) TIG welding is supplied by WWS, part numbers HP16310 – HP16340.

ALTERNATIVES: 1% Thoriated Tungstens (EWTh-1) for mild steel, HP16008 – HP16048
2% Ceriated Tungstens (EWCe-2), for AC and DC (-) TIG welding, HP16310 – HP16340

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