

TUNGSTENS

WZ TUNGSTEN ZIRCONIUM

Applications: TIG welding (welding of Al and Mg alloys)

- Arc welding
- Very stable arc



Part No	Description
10WZ8	Size 1.0 mm Zirconiated Tungsten
16WZ8	Size 1.6 mm Zirconiated Tungsten
24WZ8	Size 2.4 mm Zirconiated Tungsten
32WZ8	Size 3.2 mm Zirconiated Tungsten
40WZ8	Size 4.0 mm Zirconiated Tungsten
64WZ8	Size 6.4 mm Zirconiated Tungsten

WL TUNGSTEN LANTHANUM

Applications: TIG welding, plasma, resistance welding

- Suitable for AC welding of aluminium and magnesium
- All materials



Part No	Description
10WL20	Size 1.0 mm Lanthanated Tungsten
16WL20	Size 1.6 mm Lanthanated Tungsten
24WL20	Size 2.4 mm Lanthanated Tungsten
32WL20	Size 3.2 mm Lanthanated Tungsten
40WL20	Size 4.0 mm Lanthanated Tungsten
48WL20	Size 4.8 mm Lanthanated Tungsten
64WL20	Size 6.4 mm Lanthanated Tungsten

WT TUNGSTEN THORIUM

Applications: TIG welding, plasma

- Good general DC arc
- High current strengths
- Ease of striking



Part No	Description
W05WT20	Size 0.5 mm Thoriated Tungsten
10WT20	Size 1.0 mm Thoriated Tungsten
16WT20	Size 1.6 mm Thoriated Tungsten
24WT20	Size 2.4 mm Thoriated Tungsten
32WT20	Size 3.2 mm Thoriated Tungsten
40WT20	Size 4.0 mm Thoriated Tungsten
48WT20	Size 4.8 mm Thoriated Tungsten
64WT20	Size 6.4 mm Thoriated Tungsten

INOSTAR

Applications: TIG welding, plasma

- Mainly used for high-purity/ sensitive metals
- New rare earth mix



Part No	Description
16WI100	Size 1.6 mm Inostar Tungsten
24WI100	Size 2.4 mm Inostar Tungsten
32WI100	Size 3.2 mm Inostar Tungsten
40WI100	Size 4.0 mm Inostar Tungsten

WC TUNGSTEN CERIUM

Applications: TIG welding, resistance welding

- Universally applicable/ all materials
- Provides better ignition performance than thoriated electrodes



Part No	Description
10WC20	Size 1.0 mm Ceriated Tungsten
16WC20	Size 1.6 mm Ceriated Tungsten
24WC20	Size 2.4 mm Ceriated Tungsten
32WC20	Size 3.2 mm Ceriated Tungsten
40WC20	Size 4.0 mm Ceriated Tungsten

WS2 WITSTAR

Applications: TIG welding, plasma

- High arc stability
- Can be used for all materials
- Ideal for manual and automatic welding



Part No	Description
W05WS2	Size 0.5 mm Witstar Tungsten
10WS2	Size 1.0 mm Witstar Tungsten
16WS2	Size 1.6 mm Witstar Tungsten
24WS2	Size 2.4 mm Witstar Tungsten
32WS2	Size 3.2 mm Witstar Tungsten
40WS2	Size 4.0 mm Witstar Tungsten
48WS2	Size 4.8 mm Witstar Tungsten
64WS2	Size 6.4 mm Witstar Tungsten

ALUSTAR

Applications: TIG welding of aluminium alloys

- Specially designed for welding aluminium
- Better focus on the arc
- Perfect calotte formation



Part No	Description
16ALUSTAR	Size 1.6 mm Alustar Tungsten
24ALUSTAR	Size 2.4 mm Alustar Tungsten
32ALUSTAR	Size 3.2 mm Alustar Tungsten
40ALUSTAR	Size 4.0 mm Alustar Tungsten



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TUNGSTENS

Suggested electrode type depending on the workpiece

	WP	WS2	Inostar	WLa 10	WLa 15	WLa 20	WCe 20	Alustar	WZr8	WTh 10	WTh 20	WTh 30	WTh 40
Non - alloyed steel	-	++	+	++	++	+	+	O	O	+	+	+	+
Alloyed steel	-	++	++	O	+	++	++	O	O	O	+	++	++
Copper, alloys	-	++	+	O	+	+	+	O	O	-	+	-	-
Nickel, alloys	-	++	++	O	+	++	++	O	O	+	+	++	++
Aluminium, alloys	++	++	+	+	O	O	O	++	++	+	-	-	-
Magnesium, alloys	++	++	+	+	O	O	O	++	++	-	-	-	-
Titanium, alloys	-	++	+	-	+	+	+	-	-	-	+	++	++
Zirconium	-	++	+	O	+	+	+	-	-	-	+	++	++
Tantalum	-	+	+	O	O	++	+	-	-	-	O	++	++
Tungsten	-	+	+	O	O	++	+	-	-	-	O	++	++

Suitability: ++ very good, + good, O limited, - poor

Applications for electrode materials

	WP	WS2	Inostar	WLa10 WLa15 WLa20	WCe 20	Alustar	WZr8	WTh10 WTh20 WTh30 WTh40
Tig welding	+	++	++	++	++	++	++	++
Plasma welding	O	++	+	+	+	O	O	++
Resistance welding	++	+	+	++	++	O	O	O

Suitability: ++ very good, + good, O limited

Information and charts supplied by Wolfram



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