

# TUNGSTEN ELECTRODES

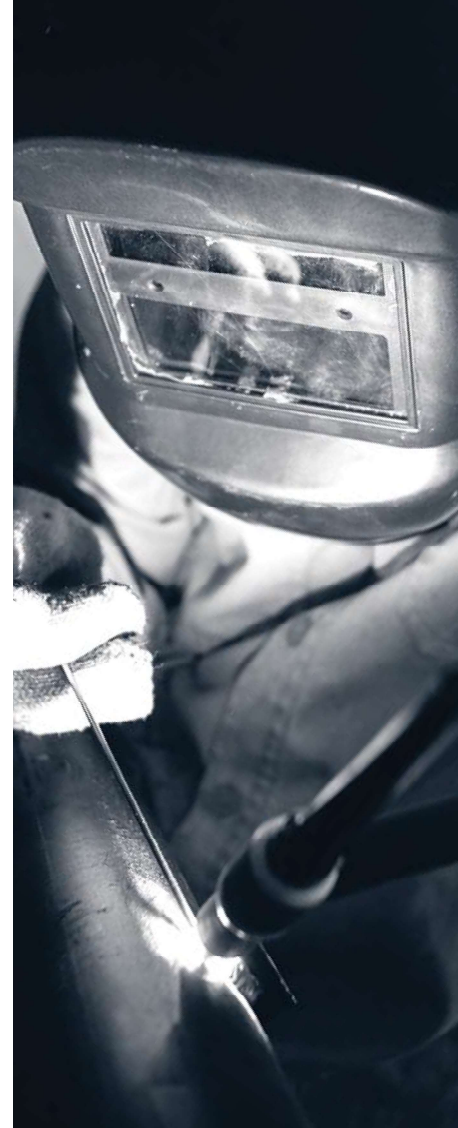
## A complete range of tungsten electrodes:

- Pure tungsten,
- Tungsten + cerium,
- Tungsten + lanthanum,
- Tungsten + rare earths <sup>(1)</sup>.

**Product advantages :**

- ◆ Very high life cycle
- ◆ Perfect arc ignition
- ◆ Very stable arc
- ◆ Tip longevity

**CAUTION:**  
before use, carefully read and understand the safety datasheet available on our websites



### Choice criteria


Type	Metal		Arc stability	Striking	Lasting	Thermal resistance
	Aluminium	Steel & Stainless steel				
WP - Pure tungsten	*		**	*	*	*
WCe 20 - Cerium 2%		*	**	*	**	**
WLa 15 - Lanthanum 1,5%	**	**	**	**	**	**
WLa 20 - Lanthanum 2%	*	**	**	**	**	**
WS 2 - Rare earths <sup>(1)</sup> 2%	*	*	**	**	**	**

\*\*\* Excellent - \*\* Good - \* Average

<sup>(1)</sup> Rare earths = any of the abundant metallic elements, including scandium (atomic number 21), yttrium (39), and the 15 elements from 57 to 71 (lanthanide series include lanthanum and cerium) in the Mendeleev classification.



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**Nertal WP** 


Ø mm	150 mm length
	To order
1.0	S03710250
1.6	S03710251
2.0	S03710252
2.4	S03710506
2.5	S03710268
3.2	S03710507
4.0	S03710254
4.8	S03710510
6.0	S03710256

**WP - Pure tungsten**  
Light alloy *(green tip)*

Ø mm	150 mm length	175 mm length
	To order	
1.0	W000010009	-
1.6	W000010010	W000010375
2.0	W000010011	W000010376
2.4	W000010012	W000010377
3.0	W000010013	-
3.2	W000010014	W000010378
4.0	W000010015	W000335152

**WLa 15 - Lanthanum 1.5%**  
Light alloy *(using AC current)*, steel and stainless steel *(using DC current)* *(gold tip)*

Ø mm	150 mm length
	To order
1.0	W000402632
1.6	W000402663
2.0	W000402664
2.4	W000402665
3.0	W000402666
3.2	W000402667
4.0	W000402668

**Nertal Ce 20** 


Ø mm	150 mm length
	To order
1.0	S03710530
1.6	S03710531
2.0	S03710533
2.4	S03710534
3.2	S03710537
4.0	S03710538
4.8	S03710539

**WCe 20 - Cerium 2%**  
Steel and stainless steel *(grey tip)*

Ø mm	150 mm length	175 mm length
	To order	
1.0	W000010022	-
1.6	W000010023	W000335153
2.0	W000010024	W000010381
2.4	W000010025	W000335154
3.0	W000010026	-
3.2	W000335150	W000335157
4.0	W000010028	W000335155

**WS 2 - Rare earths 2%**  
Light alloy *(using AC current)*, steel and stainless steel *(using DC current)* *(turquoise tip)*

Ø mm	175 mm length
	To order
1.0	W000335166
1.6	W000335167
2.0	W000335168
2.4	W000335169
3.0	W000335170
3.2	W000335171
4.0	W000335172

**Nertal La 20** 

Ø mm	150 mm length
	To order
1.6	S03710651
2.0	S03710652
2.4	S03710653
3.2	S03710655
4.0	S03710656
4.8	W000381291

**WLa 20 - Lanthanum 2%**  
Light alloy *(using AC current)*, steel and stainless steel *(using DC current)* *(blue tip)*

Ø mm	75 mm length	150 mm length	175 mm length
	To order		
1.0	W000011144	W000010373	-
1.6	W000011145	W000010016	W000010385
2.0	-	W000010017	W000010386
2.4	W000011146	W000010018	W000010387
3.0	-	W000010019	-
3.2	-	W000010020	W000010388
4.0	-	W000010021	W000010389




See the batch number on the tungsten electrode packaging and consult your conformity certificate on our websites

## Recommended welding intensities

Electrode diameter	Direct current	Alternating current	
	Tungsten with oxide addition	Pure tungsten	Tungsten with oxide addition
1.0 mm	10 A to 70 A	15 A to 55 A	15 A to 70 A
1.6 mm	20 A to 100 A	45 A to 90 A	60 A to 125 A
2.0 mm	50 A to 140 A	65 A to 125 A	85 A to 160 A
2.4 mm	70 A to 170 A	80 A to 140 A	120 A to 210 A
3.0 mm	100 A to 210 A	140 A to 180 A	140 A to 230 A
3.2 mm	130 A to 250 A	150 A to 190 A	150 A to 250 A
4.0 mm	150 A to 350 A	180 A to 260 A	240 A to 350 A