



WB22-9-3LM M.I.G. WELDING WIRE

Classifications	AWS A5.9 : ER2209		BSEN 12072 : 22 9 3 N L							
Product Description	Standard duplex stainless steel, solid MIG wire.									
Applications	<p>WB22-9-3LM finds use in the fabrication and repair of offshore installations and pipework by virtue of its high strength and corrosion resistance, can be used for welding SAF2205, UR45N & AF22.</p> <p>WB22-9-3LM is extensively used for the repair of super duplex castings, and yields excellent mechanical properties in the as-welded condition.</p> <p>Duplex structure of 30-50 ferrite gives a pitting resistance equivalent of >35.</p>									
Wire Composition(Weight %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N
min.	-	1.0	0.25	-	-	22.5	8.0	3.0	-	0.15
max.	0.03	2.0	0.65	0.020	0.030	23.5	9.5	3.5	0.5	0.20
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		690 min.					
	Yield Stress/0.2% Proof Stress		N/mm ²		450 min.					
	Elongation on 5D		%		20 min.					
	Impact Energy CV @ -50oC as-welded		Joules		>120					

Wire Dia (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	80	120	160	180	-	-
	max.	-	180	240	260	300	-	-
Volt Range (Volts)	min.	-	17	17	18	20	-	-
	max.	-	20	22	26	29	-	-
Packaging Information								
Kg Per Reel		-	0.7/15	15	15	15	-	-
Storage	<p>Storage</p> <p>It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.</p>							
Gases	<p>Gas</p> <p>Pure Argon or Argon + 2%O₂ mixture</p> <p>Flow Rate</p> <p>12-16 l/min</p>							

Current Conditions DC+ and Welding Positions

