



WB25-9-3LM M.I.G. WELDING WIRE

Classifications BSEN ISO 14343-A-09 : W 25 9 4 N L AWS A5.9-06 : ER2594

Product Description Super Duplex stainless steel, solid MIG wire.

Applications WB25-9-3LM 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 SAF2507, UR52N+ & UR47N.
 WB25-9-3LM is extensively used for the repair of super duplex castings, and yields excellent mechanical properties in the as-welded condition.
 Duplex structure of 30-60 ferrite gives a pitting resistance equivalent of >40.

Wire Composition(Weight %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N
min.		-	0.5	0.50	-	-	24.5	9.0	3.5	0.5	0.2
max.		0.03	1.0	1.00	0.01	0.03	26.0	10.0	4.0	1.0	0.3
		W									
min.		0.5									
max.		1.0									

Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength	N/mm ²	750 min.
	Yield Stress/0.2% Proof Stress	N/mm ²	550 min.
	Elongation on 5D	%	20 min.
	Impact Energy CV @ -70oC as-welded	Joules	>60

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	-	15	15	15	15	-	-
Storage	Storage 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%.						
Gases	Gas Pure Argon or Argon + 2%O ₂ mixture						
	Flow Rate 12-16 l/min						

Current Conditions DC+ and Welding Positions

