



WB62293L FLUX CORED WELDING WIRE

Classifications	AWS A5.22-95 : E2209T0-4									
Product Description	Rutile, stainless steel, formed, flux cored, welding wire. Fully positional.									
Applications	WB62293L is used mainly for welding 22Cr duplex steels, such as SAF2205, A903, VS22, UR45N, AF22 (1.4462) & UR35N. Ferrite 30-50FN range. PRE >35									
Wire Composition(Weight %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N
min.	0.02	1.0	0.50	-	-	21.5	8.5	2.8	-	0.08
max.	0.04	1.5	0.80	0.025	0.025	24.0	10.0	4.0	0.50	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		480 min.					
	Elongation on 4D		%		20 min.					
	Impact Energy CV @ -60°C		Joules		47 min.					
	as-welded									

Wire Dia (mm)		0.6mm	0.8mm	0.9mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	80	120	200	-	-
	max.	-	-	160	280	330	-	-
Volt Range (Volts)	min.	-	-	22	22	26	-	-
	max.	-	-	32	34	36	-	-
Packaging Information								
Kg Per Reel		-	-	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 80% Argon 20% CO ₂ mixture or CO ₂ Flow Rate 12-16 l/min							

Current Conditions DC+ and Welding Positions

