



# WB62293LP FLUX CORED WELDING WIRE

<b>Classifications</b>	AWS A5.22-95 : E2209T1-4									
<b>Product Description</b>	All positional, rutile, stainless steel, formed, flux cored, welding wire. Fully positional.									
<b>Applications</b>	WB62293LP is used mainly for welding 22Cr duplex steels, such as SAF2205, A903, VS22, UR45N, AF22 (1.4462) & UR35N.  Ferrite 30-70FN range. PRE >35 . G48 @ 25°C.									
<b>Wire Composition(Weight %)</b>	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N
<b>min.</b>	-	0.5	0.30	-	-	22.0	8.5	3.0	-	0.14
<b>max.</b>	0.03	2.0	0.80	0.010	0.010	23.5	9.5	3.5	0.2	0.20
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength				N/mm <sup>2</sup>	>690				
	Yield Stress/0.2% Proof Stress				N/mm <sup>2</sup>	>580				
	Elongation on 4D				%	>25				
	Impact Energy CV @ -50°C as-welded				Joules	35				

<b>Wire Dia (mm)</b>		0.6mm	0.8mm	0.9mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>min.</b>	-	-	80	120	200	-	-
	<b>max.</b>	-	-	160	280	330	-	-
<b>Volt Range (Volts)</b>	<b>min.</b>	-	-	22	22	26	-	-
	<b>max.</b>	-	-	32	34	36	-	-
<b>Packaging Information</b>								
<b>Kg Per Reel</b>		-	-	15	15	15	-	-
<b>Storage</b>	<b>Storage</b> 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%.							
<b>Gases</b>	<b>Gas</b> 80% Argon 20% CO <sub>2</sub> mixture  <b>Flow Rate</b> 12-16 l/min							

## Current Conditions DC+ and Welding Positions

