



WB62593L-P FLUX CORED WELDING WIRE

Classifications	~AWS A5.22-95 : E25533T1-4										
Product Description	Rutile, 25Cr Super Duplex, stainless steel, formed, flux cored, welding wire. Fully positional.										
Applications	<p>WB62593L-P is used mainly for welding and repairing of duplex (Austenitic/Ferritic) alloys such as UNS S32760 (wrought), UNS J99680 (cast), Sandvik SAF 2507 and UR52N.</p> <p>Used extensively in the oil & gas industry and process pipework, risers, manifolds and the repair of matching castings.</p> <p>30-60% ferrite with a PRE_N of >40.</p>										
Wire Composition(Weight %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N
min.		0.02	0.80	0.50	-	-	24.5	8.0	3.0	0.08	0.20
max.		0.04	1.25	0.80	0.015	0.020	26.5	9.5	4.2	0.12	0.30
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm ²	910				
	Yield Stress/0.2% Proof Stress					N/mm ²	690				
	Elongation on 4D					%	28				
	Impact Energy CV @ -40°C as-welded					Joules	>37				

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 75% Argon 25% CO ₂ mixture or 80% Argon 20% CO ₂ mixture Flow Rate 12-16 l/min							

Current Conditions DC+ and Welding Positions

