



WB62593L FLUX CORED WELDING WIRE

Classifications AWS A5.22-95 : E25533TO-1 BSEN 12073 – T Z 25 9 4 Cu N L R M 3

Product Description Semi-Basic, stainless steel, formed, flux cored, welding wire. With maximum performances in the down hand position.

Applications WB62593L is used mainly for welding and repairing of duplex (Austenitic/Ferritic) alloys such as UNS S32760 (wrought), UNS J99680(cast), Sandvik SAF 2507, UR52N and WMS ZERON 100R®. Used extensively in the oil & gas industry and process pipework, risers, manifolds and the repair of matching castings.
30-60% ferrite with a PRE_N of >40.

| Wire Composition(Weight %) | | C | Mn | Si | S | P | Cr | Ni | Mo | Cu | N |
|----------------------------|--|------|-----|------|-------|-------|------|-----|-----|------|------|
| min. | | 0.02 | 1.2 | 0.50 | - | - | 24.5 | 8.0 | 2.8 | 0.80 | 0.20 |
| max. | | 0.04 | 1.6 | 0.80 | 0.015 | 0.020 | 26.5 | 9.5 | 4.0 | 1.10 | 0.30 |

| Typical All-Weld Metal Mechanical Properties | Ultimate Tensile Strength | N/mm ² | 950 |
|--|------------------------------------|-------------------|-----|
| | Yield Stress/0.2% Proof Stress | N/mm ² | 830 |
| | Elongation on 4D | % | 20 |
| | Impact Energy CV @ -50°C as-welded | Joules | >27 |

| 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 | 0.6mm | 0.8mm | 0.9mm | 1.2mm | 1.6mm | 2.4mm | 3.2mm |
|-------------|-------|-------|-------|-------|-------|-------|-------|
| | - | - | 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% CO₂ mixture or CO₂

Flow Rate 12-16 l/min

Current Conditions DC+ and Welding Positions

