



WB25-9-3LT T.I.G. WELDING WIRE

Classifications BSEN 12072-2000: W 25 9 4 N L AWS A5.9-06 : ER2594

Product Description Super duplex stainless steel, solid TIG wire.

Applications

WB25-9-3LT 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, UNS S32760, UR52N+ & UR47N.
 WB25-9-3LT 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
			-	0.5	-	-	-	24.5	9.0	3.5	0.5
	min.	0.03	1.0	1.00	0.01	0.03	26.0	10.0	4.0	1.0	0.3
	max.										
		W									
	min.	0.5									
	max.	1.0									

Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength	N/mm ²	750
	Yield Stress/0.2% Proof Stress	N/mm ²	550
	Elongation on 5D	%	20
	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	100	130
	max.	-	-	-	-	120	160	230
Volt Range (Volts)	min.	-	-	-	-	-	-	-
	max.	-	-	-	-	-	-	-

Packaging Information

Kg Per Tube	-	-	-	-	5	5	5
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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%.

Gas
 Argon with 2% Nitrogen shielding gas and pure Argon for inert gas backing.

Gases
Flow Rate
 7-10 l/min

Current Conditions DC- and Welding Positions

