

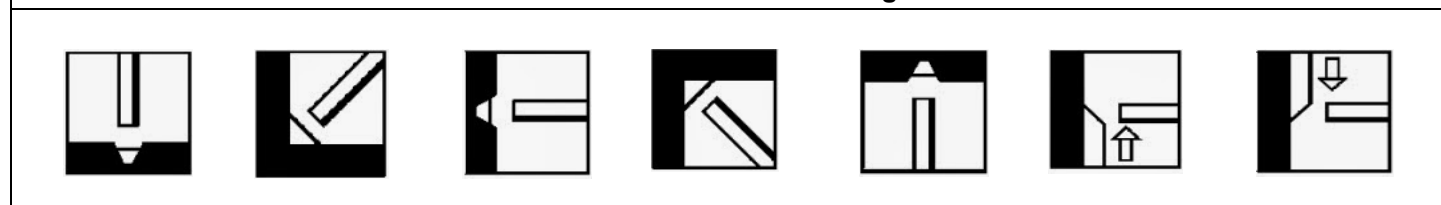


WB25-9-3LT TIG WELDING WIRE

Classifications	AWS A5.9: ER 25 9 4 BS EN ISO 14343-A: W 25 9 4 N L										
Product Description	Super duplex stainless steel TIG wire. G48 @+65°C										
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, UNSS 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 (Wt. %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N	
	min. - max. 0.03	0.5 1.0	- 1.00	- 0.01	- 0.03	24.5 26.0	9.0 10.0	3.5 4.0	0.5 1.0	0.2 0.3	
	W	H	O								
	min. 0.5 max. 1.0	<3ppm	<2ppm								
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm ²	750 min.				
	Yield Stress/0.2% Proof Stress					N/mm ²	550 min.				
	Elongation on 5D					%	20 min.				
	Impact Energy CV @ -101°C					Joules	>100				
	As welded										

Wire dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	-	-	60	70	80
	max.	-	-	-	-	120	180	220
Volt Range (Volts)	min.	-	-	-	-	-	-	-
	max.	-	-	-	-	-	-	-
Packaging Information								
Kg Per Tube		-	-	-	-	5.0	5.0	5.0
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 Pure Argon				Flow Rate 12-14 L/min			

Current Conditions DC- and Welding Positions



Approvals: CE