



WB62293L FLUX CORED WELDING WIRE

Classifications	AWS A5.22: E2209T0-1/4 BS EN ISO 17633-A: T 22 9 3 N L R									
Product Description	Rutile, stainless steel, formed, flux cored, welding wire. This wire is specially designed for use in the downhand position.									
Applications	WB62293L is used mainly for welding 22Cr duplex steels, such as SAF2205, A903, VS22, UR45N, AF22 (1.4462) & UR35N. Ferrite 30-50FN range. PRE >35									
Wire Composition (Wt. %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N
min.	0.02	1.0	0.50	-	-	21.5	8.5	2.8	-	0.08
max.	0.04	1.5	0.80	0.025	0.025	24.0	10.0	4.0	0.50	0.20
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		690 min.					
	Yield Stress/0.2% Proof Stress		N/mm ²		480 min.					
	Elongation on 4D		%		20 min.					
	Impact Energy CV @ -60°C		Joules		47 min.					
	As welded									

Wire dia. (mm)		0.6mm	0.8mm	0.9mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	100	120	200	-	-
	max.	-	-	220	300	380	-	-
Volt Range (Volts)	min.	-	-	17	18	22	-	-
	max.	-	-	28	30	32	-	-
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 80% Argon 20% CO ₂ mixture or CO ₂ Flow Rate 15-20 L/min							

Current Conditions DC+ and Welding Positions

