



## WB22-9-3LM MIG WELDING WIRE

<b>Classifications</b>	<b>AWS A5.9:</b> ER2209		<b>BS EN ISO 14343-A:</b> G 22 9 3 N L								
<b>Product Description</b>	Standard duplex stainless steel, solid MIG wire.										
<b>Applications</b>	<p>WB22-9-3LM 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 SAF2205, UR45N &amp; AF22.</p> <p>WB22-9-3LM is extensively used for the repair of super duplex castings and yields excellent mechanical properties in the as-welded condition.</p> <p>Duplex structure of 30-50 ferrite gives a pitting resistance equivalent of &gt;35. H2&lt;3ppm</p>										
<b>Wire Composition (Wt. %)</b>		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N
<b>min.</b>		-	1.0	0.25	-	-	22.5	8.0	3.0	-	0.15
<b>max.</b>		0.03	2.0	0.65	0.020	0.030	23.5	9.5	3.5	0.5	0.20
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength		N/mm <sup>2</sup>		690 min.						
	Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>		450 min.						
	Elongation on 5D		%		20 min.						
	Impact Energy CV @ -50°C		Joules		>120						
	As welded										

<b>Wire Dia. (mm)</b>		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>min.</b>	-	80	120	160	180	-	-
	<b>max.</b>	-	180	240	280	340	-	-
<b>Volt Range (Volts)</b>	<b>min.</b>	-	17	17	18	20	-	-
	<b>max.</b>	-	20	22	28	29	-	-
<b>Packaging Information</b>								
<b>Kg Per Reel</b>		-	0.7/15	15	15	15	-	-
<b>Storage</b>	<b>Storage</b> 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%.							
<b>Gases</b>	<b>Gas</b> Pure Argon or Argon + 2% O <sub>2</sub>				<b>Flow Rate</b> 15-20 L/min			

### Current Conditions DC+ and Welding Positions

