WB62593LP FLUX CORED WELDING WIRE

Classifications	**AWS A5.22:** E2594T1-1/4 **BS EN ISO 17633-A:** T 25 9 4 Cu N L P M21 1
Product Description	Rutile, 25Cr Super Duplex, stainless steel, formed, flux cored, welding wire. Fully positional.
Applications	WB62593L-P is used mainly for welding and repairing of duplex (Austenitic/Ferritic) alloys such as UNS S32760 (wrought), UNS J99680 (cast), Sandvik SAF 2507 and UR52N. 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 (Wt. %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N
min.	0.02	0.80	0.50	-	-	24.5	8.0	3.0	1.0	0.20
max.	0.04	1.25	0.80	0.015	0.020	26.5	9.5	4.2	2.5	0.30

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm^2	910
Yield Stress/0.2% Proof Stress	N/mm^2	690
Elongation on 4D	%	28
Impact Energy CV @ -46°C	Joules	>50
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 **Flow Rate** 15-20 L/min

Current Conditions DC+ and Welding Positions

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