

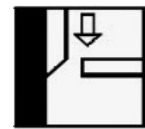
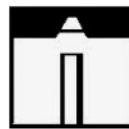
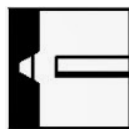
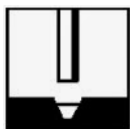


WB22-9-3LT TIG WELDING WIRE

Classifications	AWS A5.9: ER 2209 BS EN ISO 14343-A: W 22 9 3 N L										
Product Description	Standard duplex stainless steel TIG wire.										
Applications	<p>WB22-9-3LT 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 SAF2205, UR45N & AF22.</p> <p>WB22-9-3LT is extensively used for the repair of 22Cr 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 >35.</p>										
Wire Composition (Wt. %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N
min.		-	1.0	0.25	-	-	22.5	8.0	3.0	-	0.15
max.		0.03	2.0	0.65	0.020	0.030	23.5	9.5	3.5	0.5	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		450 min.						
	Elongation on 5D		%		20 min.						
	Impact Energy CV @ -50oC		Joules		>120						
	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