



WB25-9-3LM MIG WELDING WIRE

Classifications	AWS A5.9: ER2594		BS EN ISO 14343-A: G 25 9 4 NL							
Product Description	Super duplex stainless steel, solid MIG wire.									
Applications	<p>WB25-9-3LM 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 SAF2507, UR52N+ & UR47N.</p> <p>WB25-9-3LM 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 30-60 ferrite gives a pitting resistance equivalent of >40.</p>									
Wire Composition (Wt. %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N
	min. max.	- 0.03	0.5 1.0	0.50 1.00	- 0.01	- 0.03	24.5 26.0	9.0 10.0	3.5 4.0	0.5 1.0
	W									
	min. max.	0.5 1.0								
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 @ -70°C		Joules		>60					
	As welded									

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	80	120	160	180	-	-
	max.	-	180	240	260	300	-	-
Volt Range (Volts)	min.	-	17	17	18	20	-	-
	max.	-	20	22	28	30	-	-
Packaging Information								
Kg Per Reel		-	15	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 Pure Argon or Argon + 2%O ₂ mixture							
	Flow Rate 15-20 L/min							

Current Conditions DC+ and Welding Positions

