



# WB62293LP FLUX CORED WELDING WIRE

<b>Classifications</b>	<b>AWS A5.22-95:</b> E2209T1-1/4 <b>BS EN ISO 17633-A:</b> T 22 9 3 N L P																																											
<b>Product Description</b>	All positional, rutile, stainless steel, formed, flux cored, welding wire. Fully positional.																																											
<b>Applications</b>	WB62293LP is used mainly for welding 22Cr duplex steels, such as SAF2205, A903, VS22, UR45N, AF22 (1.4462) & UR35N.  Ferrite 30-70FN range. PRE >35. G48 @ 25°C.																																											
<b>Wire Composition (Wt. %)</b>	<table border="1"> <thead> <tr> <th></th> <th>C</th> <th>Mn</th> <th>Si</th> <th>S</th> <th>P</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Cu</th> <th>N</th> </tr> </thead> <tbody> <tr> <td>min.</td> <td>-</td> <td>0.5</td> <td>0.30</td> <td>-</td> <td>-</td> <td>22.0</td> <td>8.5</td> <td>3.0</td> <td>-</td> <td>0.14</td> </tr> <tr> <td>max.</td> <td>0.03</td> <td>2.0</td> <td>0.80</td> <td>0.010</td> <td>0.010</td> <td>23.5</td> <td>9.5</td> <td>3.5</td> <td>0.2</td> <td>0.20</td> </tr> </tbody> </table>												C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N	min.	-	0.5	0.30	-	-	22.0	8.5	3.0	-	0.14	max.	0.03	2.0	0.80	0.010	0.010	23.5	9.5	3.5	0.2	0.20
	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N																																		
min.	-	0.5	0.30	-	-	22.0	8.5	3.0	-	0.14																																		
max.	0.03	2.0	0.80	0.010	0.010	23.5	9.5	3.5	0.2	0.20																																		
<b>Typical All-Weld Metal Mechanical Properties</b>	<table border="1"> <tbody> <tr> <td>Ultimate Tensile Strength</td> <td>N/mm<sup>2</sup></td> <td>&gt;690</td> </tr> <tr> <td>Yield Stress/0.2% Proof Stress</td> <td>N/mm<sup>2</sup></td> <td>&gt;580</td> </tr> <tr> <td>Elongation on 4D</td> <td>%</td> <td>&gt;25</td> </tr> <tr> <td>Impact Energy CV @ -50°C</td> <td>Joules</td> <td>35</td> </tr> </tbody> </table> <p>As welded</p>		Ultimate Tensile Strength	N/mm <sup>2</sup>	>690	Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	>580	Elongation on 4D	%	>25	Impact Energy CV @ -50°C	Joules	35																														
Ultimate Tensile Strength	N/mm <sup>2</sup>	>690																																										
Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	>580																																										
Elongation on 4D	%	>25																																										
Impact Energy CV @ -50°C	Joules	35																																										

Wire Dia. (mm)		0.6mm	0.8mm	0.9mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	min.	-	-	100	120	200	-	-
	max.	-	-	220	300	380	-	-
<b>Volt Range (Volts)</b>	min.	-	-	17	18	22	-	-
	max.	-	-	28	30	32	-	-
<b>Packaging Information</b>								
<b>Kg Per Reel</b>		-	-	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> 80% Argon 20% CO <sub>2</sub> mixture  <b>Flow Rate</b> 15-20 L/min							

## Current Conditions DC+ and Welding Positions

