



WB62593L FLUX CORED WELDING WIRE

Classifications	AWS A5.22: E25533T0-1/4 BS EN ISO 17633-A: T Z 25 9 4 Cu N L R M 3										
Product Description	Semi-Basic, stainless steel, formed, flux cored, welding wire. Specially designed for use in the horizontal and down hand positions.										
Applications	WB62593L is used mainly for welding and repairing of duplex (Austenitic/Ferritic) alloys such as UNS S32760 (wrought), UNS J99680(cast), Sandvik SAF 250 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	1.2	0.50	-	-	24.5	8.0	2.8	0.80	0.20
	max.	0.04	1.6	0.80	0.015	0.020	26.5	9.5	4.0	1.10	0.30
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		950						
	Yield Stress/0.2% Proof Stress		N/mm ²		830						
	Elongation on 4D		%		20						
	Impact Energy CV @ -50°C		Joules		>47						
	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 or CO ₂ Flow Rate 15-20 L/min							

Current Conditions DC+ and Welding Positions

