



WB62593L FLUX CORED WELDING WIRE

Classifications	AWS A5.22: E2594T0-1/4 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	<p>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.</p> <p>Used extensively in the oil & gas industry and process pipework, risers, manifolds and the repair of matching castings.</p> <p>30-60% ferrite with a PRE_N of >40.</p>																					
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	<table> <tr> <td>Ultimate Tensile Strength</td> <td>N/mm²</td> <td>950</td> </tr> <tr> <td>Yield Stress/0.2% Proof Stress</td> <td>N/mm²</td> <td>830</td> </tr> <tr> <td>Elongation on 4D</td> <td>%</td> <td>20</td> </tr> <tr> <td>Impact Energy CV @ -50°C</td> <td>Joules</td> <td>>47</td> </tr> </table> <p>As welded</p>										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
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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	<p>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%.</p>							
Gases	<p>Gas 80% Argon 20% CO₂ mixture or CO₂</p> <p>Flow Rate 15-20 L/min</p>							

Current Conditions DC+ and Welding Positions

