

Classifications

EN ISO 3581-A:2012	: E 25 9 4 N L R 12
EN ISO 3581-B:2012	: ES2594-16
AWS A5.4-06	: E2594-16

Description

- Covering is lime titania type for welding of 25%Cr-9%Ni-4%Mo-0.2%N super duplex stainless steels, the principal applications are chemical plant and shipbuilding as well as nuclear plant industries. (UNS S32750)
- Excellent pitting corrosion resistance and stress corrosion cracking resistance.
- Please perform welding with selecting proper heat input according to the required mechanical properties.
- Redry the electrode at 250~350°C for 30~60 minutes prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	N	PREN
0.03	0.54	0.75	0.025	0.011	9.59	25.11	3.90	0.25	42.0

Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.4		min. 760	min. 15	
EN ISO 3581-A	min. 550	min. 620	min. 18	
Example	810	930	28	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	350
Amp.	F	50~80	80~110	110~150	140~180
(A)	V · OH	40~60	70~100	90~130	-