FCW 2509Mo

High productivity super duplex
Flux cored wire

Classification

AWS A5.22 : ~E2594T0-4

ISO 17633-A : T Z 25 9 4 Cu N L R M21 3

Description & Applications

Flux cored wire for gas shielded (Ar + CO_2) arc welding in flat and down hand positions for Duplex and Super Duplex steels such as Uranus 45N*, 52N, 2205, 2304, 2507. Resistant to severe corrosive environments (inter crystalline attack, pitting corrosion, crevice, stress corrosion). For all construction with service temperature up to 250°C.

Main applications: For pumps, vessels, piping systems etc. attacked by chloride containing solutions. But also for impellers and other components which require high strength combined with corrosion attack.

Base materials:

UNS	Alloy	EN 10088	N° de Mat	CLI
S31803		X2CrNiMoN22-5-3	1.4462	URANUS 45
S32304	35N	X2CrNi23-4	1.4362	URANUS 35N
S32550	52N	G-X2CrNiMoCuN26 6 3	1.4517	URANUS 52N
	52N+	X2CrNiMoCuN25-6-3	1.4507	URANUS 52N+
S32750	2507	X2CrNiMoN25-7-4	1.4410	
S32760	100	X2CrNiMoCuWN25-7-4	1.4501	URANUS 70N

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	N2	P	S	Fe
0.03	0.60	1.4	25.0	9.0	3.8	1.0	0.26	0.015	0.008	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)		PREN
830	950	22	-29°C	30	> 40

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2 1.6	130 - 250 150 - 300	24 - 35 24 - 35	12 - 20 12 - 25	ISO 14175 : M21 (Ar/CO_2) 10 - 20 l/min

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