Selectarc Inox 2509MoB

Basic Coated Electrode
For Super-Duplex Stainless Steels

Classification

AWS A5.4 : E2594-15
ISO 3581-A : E 25 9 4 N L B 4 2
EN1600 : E 25 9 4 N L B 4 2

Description & Applications

Basic coated electrode with an austenitic - ferritic microstructure (duplex ~ 40% ferrite). The weld metal can be applied for operation temperatures up to 250°C and is resistant in chloride containing medias against pitting as well as crevice and stress corrosion.

Main applications: For but welding and cladding of steels and castings with an austenitic - ferritic structure, of the same or similar composition, which are used 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. Pitting index: > 40.

Base materials

UNS	Alloy	EN 10088	Material N°	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
S32900	329	X3CrNiMoN27-5-2	1.4460	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	N	Fe
<0.04	0.5	1.5	25.0	9.5	4.0	0.7	0.23	base

All Weld Metal Mechanical Properties

$R_{p0,2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
720	850	25	+20°C 70 -40°C 45

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350
Current	(A)	50-75	70-100	90-150

Redrying 2-3 hours at 250-300°C. Guide electrodes with a slight declination and weld with a short arc. Interpass temperature: <150°C.

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