Inox 2509MoWB

Basic coated Electrode
For Super-duplex Stainless steels

Classification

AWS A 5.4 : E 2595-15
ISO 3581-A : E 25 9 4 N L B 4 2

EN 1600 : 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. 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 solution. But also for impellers and other components which require high strength combined with corrosion attack. Pitting index: >40.

Main applications: Tanks, pumps, piping systems…

Base materials

UNS	Aciers	EN 10088	N° 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+
S32760	100	X2CrNiMoCuW25 7 4	1.4501	URANUS 70N
S32900	329	X3CrNiMoN27-5-2	1.4460	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	W	Cu	N	Fe
<0.04	0.5	1.5	25.0	9.3	3.6	0.5	0.7	0.23	Base

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
700	900	24	+20°C 75 -50°C 50

Welding Current & Instructions

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

Redrying 2-3h at 250-300°C, if necessary. Interpass temperature: <130°C. Guide electrodes with a slight declination and weld with a short arc.

ind.10



= +

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.