TIG D25/09

Old reference: TIG 2509

Classification

AWS A5.9 : ER2594 UNS : S32750
ISO 14343-A : W 25 9 4 N L

Description & Applications

Very low carbon content solid GTAW rod for joining Duplex and Super Duplex Stainless Steels (austenitic-ferritic microstructure). Resistant in chloride containing media against pitting corrosion as well as crevice and stress corrosion. Pitting index (PREN): > 40.

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	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 Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	N_2	P	S	Fe
0.012	0.5	0.6	25.5	9.2	4.0	0.25	<0.03	<0.015	Rem.

All Weld Metal Mechanical Properties

$R_{p0,2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
630	820	25	+20°C 130
			-40°C 90

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon/Nitrogen : 3-6 l/min

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