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Inox 2509MoWB

Basic Coated Electrode for Super-Duplex Stainless Steels

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Classification

AWS A5.4 : E2595-15
ISO 3581-A : E 25 9 4 N LB 42
EN1600 : E 25 9 4 N LB 42

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 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
S32750	2507	X2CrNiMoN25-7-4	1.4410	
S32760	100	X2CrNiMoCuWN25-7-4	1.4501	URANUS 70N

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	W	Cu	N	Fe
0.03	0.5	1.2	25.0	9.3	3.7	0.6	0.7	0.23	base

All Weld Metal Mechanical Properties

$R_{p0,2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
660	850	24	+20°C 70 -50°C 45

Welding Current & Instructions

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

Rebaking : 2-3 hours at 250-300°C. Guide electrodes with a slight declination and weld with a short arc.
Interpass temperature : < 130°C.

1G/PA 2F/PB 2G/PC 3G/PF 4G/PE

= +

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