



Selectarc Inox 2608MoB

**Basic Coated Electrode
For Super-Duplex Stainless Steels**

Classification

AWS A5.4 : E2594-15

ISO 3581-A: E 25 9 4 N L B 42

Description & Applications

Basic coated electrode with an austenitic-ferritic microstructure (duplex ~ 50% 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 welding of steels and castings with an austenitic - ferritic structure, of the same or similar composition, which are used for pumps, valves and other parts attacked by chloride containing solutions. Easy to weld with, stable arc, easy to remove slag, regular weld beads.

Pitting index: > 40.

Base materials:

UNS	Alloy	EN 10088	Material N°
S32550	52N	G-X2CrNiMoCuN26 6 3	1.4517
S32750	2507	X2CrNiMoN25-7-4	1.4410
S32760	100	X2CrNiMoCuWN25-7-4	1.4501
J93404		GX2CrNiMoN26-7-4	1.4469

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	N	Fe	FN
0.03	0.5	1.5	26.0	8.5	4.0	0.7	0.21	Rem.	50

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)
720	850	25

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350	5,0x450
Current (A)		50-75	70-100	90-150	140 - 160

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

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