



FCW 2509MoP

All position super duplex
Flux cored wire

Classification

AWS A5.22 : ~E2594T-1

ISO 17633-A : T Z 25 9 4 Cu N L P M21 1

Description & Applications

Flux cored wire for gas shielded (Ar + CO₂) arc welding in all positions for Super Duplex steels such as Uranus 45N*, 52N, 2205, 2304, 2507. Resistant to severe corrosive environments (inter crystalline attack, pitting corrosion, crevice, stress corrosion). For all construction with service temperature up to 250°C. Wire with rutile fast freezing to weld in all positions.

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

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	N2	P	S	Fe
0.03	0.60	1.4	25.0	9.4	3.8	1.5	0.24	0.015	0.008	Rem.

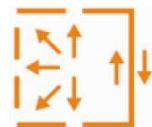
All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	PREN
710	890	24	-29°C 30	> 40

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	130 - 250	24 - 35	12 - 20	ISO 14175 : M21 (Ar/CO ₂) 10 - 20 l/min

FT En-CN21-160211



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