



## SELECTARC Inox 2608MoB

### Basic Coated Electrode for Super-Duplex Stainless Steel

#### Classification

AWS A5.4 : E2594 - 15

ISO 3581-A

: E 25 9 4 N L B 42

#### Charasterstics

Basic coated electrode with an austenitic-ferritic microstructure (duplex ~ 50% ferrite). The weld metal can be applied for service temperature upto 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. Easy to weld with stable arc. Easy to remove slag. Uniform weld beads. Pitting index : >40.

#### Applications

Used for Pumps, Valves and other parts attacked by chloride containing solutions.

#### Base Materials

UNS	ALLOY	EN 10088	Material N <sup>o</sup>	CLI
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 Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	N	S	P	Fe
0.03	0.50	1.50	26.0	8.50	4.00	0.70	0.25	0.010	0.020	base

#### All Weld Metal Mechanical Properties (Typical)

Conditions	UTS	YS	% Elg A <sub>s</sub>	Impact (KV)		FN (WRC)
	R <sub>m</sub> (MPa)	R <sub>p0.2</sub> (MPa)		Temp. °C	J	
AW	850	720	25	- 50	45	62

#### Welding Current & Instructions

Electrode	ØxL (mm)	2.5 x 300	3.2 x 350	4.0 x 350	5.0 x 450
Current	(A)	50 - 75	70 - 100	90 - 150	140 - 160

Redrying of Electrode for 2-3 hrs at 250 - 300°C before use. Guide electrodes with a slight inclined angle of travel with a short arc. Maintain Interpass temperature : < 150°C.



1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

= + ~ 70 V

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