

Classification

AWS A5.9 : ER2594
ISO 14343 : G 25 9 4 N L

UNS : S32750

Description & Applications

Solid wire electrode with very low carbon content for joining Duplex stainless steels (austenitic-ferritic microstructure) .Resistant in chloride containing media against pitting corrosion 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 attacked by chloride containing solutions. But also for impellers and other components which require high strength combined with corrosion attack. Pitting index: > 40.

Main applications: For pumps, vessels, piping systems.

Base materials

UNS	Alloy	EN 10088	Material N°	CLI
S31803		X2CrNiMoN22-5-3	1.4462	URANUS 45
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	Cu	N ₂	P	S	WRC
0.012	0.4	0.6	25.2	9.3	4.0	0.1	0.25	0.02	0.01	~50FN

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
660	880	25	+20°C 90

Welding Current & Instructions

Welding mode	Ø wire (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG =+	0.8	100-150	22-27	Ar+20%He+0.05% CO ₂
	1.0	120-200	24-28	
	1.2	140-220	24-28	Ar + 2%CO ₂ 18-20 l/min
	1.6	180-260	24-30	

Ind.09



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