

# TIG 52N



## Classification

EN 12072 : W Z 25 7 3 CuNL  
AWS A5.9 : ER2553

## Description & Applications

Solid rod for joining Super Duplex steels (austenitic-ferritic microstructure)  
Super Duplex stainless steels are used in seawater environments, for Offshore applications, for the production and transport of phosphoric acid, in the pulp and paper industry, etc.

## Typical Chemical Composition ( % )

C	Si	Mn	Cr	Ni	Mo	Cu	N <sub>2</sub>	P	S	Fe
0.02	0.5	1.5	25.5	6.3	3.2	1.7	0.24	<0.02	<0.02	Base

## All Weld Metal Mechanical Properties

Rp0.2 ( MPa )	Rm ( MPa )	A5 ( % )	KV ( J )
600	800	30	+20°C : 90

## Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar 98%+N2 2% : 6-12 l/min Back shielding : Argon/Nitrogen : 3-6 l/min

