

## Classifications

<b>EN ISO 3581-A</b>	<b>AWS A5.4</b>
E 25 9 3 Cu N L R 1 2	E2593-16

## Characteristics and typical fields of application

Rutile-basic coated stick electrode for welding stainless super duplex steels.

Resistant to intercrystalline corrosion – wet corrosion at 250 °C (482 °F). Corrosion resistance superior to that of Thermanit 22/09 (W). Good resistance to stress corrosion cracking in chlorine and hydrogen sulphide bearing environments. The high Cr and Mo contents provide resistance to pitting corrosion.

## Base materials

1.4515 – GX3CrNiMoCuN26-6-3;                      1.4517 – GX3CrNiMoCuN26-6-3-3

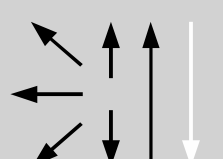
## Typical analysis of all-weld metal

	C	Si	Mn	Cr	Mo	Ni	N	Cu
wt-%	0.02	0.7	0.9	25.0	3.0	9.0	0.1	2.0

**Structure:** Austenite/ferrit

Heat-treatment	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J
	MPa	MPa	%	+20 °C
aw	470	600	23	35

## Operating data

	Polarity: DC (+) / AC	ø mm	L mm	Amps A
		3.2	350	60 – 110
		4.0	350	90 – 150

## Welding instruction

Materials	Preheating	Postweld heat treatment
Matching / similar steels / cast steel grades	None	Mostly none; if necessary solution annealing at 1120 °C (2048 °F) / water

## Approvals

TÜV (05200.), CE