



SELECTARC UP 2509

SAW Wire Electrode

Classification

AWS A5.9 : ER2594

ISO 14343-A

: S 25 9 4 NL

Characteristics

Solid wire for submerged arc welding of Super Duplex stainless steels (austenitic-ferritic microstructure). Resistant in chloride containing media against pitting corrosion as well as crevice and stress corrosion. Pitting index >40.

Applications

Butt welding and cladding of steels with an austenitic - ferritic structure, of the same or similar composition, which are used 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	DIN	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 Wire Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	N	P	S	Fe
0.012	0.40	0.60	25.20	9.30	4.00	0.10	0.25	0.020	0.010	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS	YS	% Elg	Impact (KV)	
	R _m (MPa)	R _{p0.2} (MPa)	A ₅	Temp.°C	J
AW	880	700	26	+ 20	80
				- 40	55

Welding Current & Instructions

Process	Ø (mm)	Welding Parameters			Flux
		Current (A)	Voltage (V)	Speed cm/mim	
SAW = +	2.4	340 - 380	28 - 29	48 - 60	UP WP 380M
	2.8	360 - 430	28 - 29	48 - 60	
	3.2	450 - 550	28 - 29	48 - 60	

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