

4460Cu

CATEGORY	SMAW Stick Electrodes	
TYPE	Rutile-Basic stainless steel electrode with extreme high corrosion resistance and mechanical properties.	
APPLICATIONS	Welding wrought, forged or cast super duplex stainless steels for service in the as-welded condition. Heterogeneous welding between super duplex stainless steels and dissimilar welds between other stainless and mild or low alloyed steels	
PROPERTIES	Higher corrosion resistance than standard Duplex steels with also higher mechanical properties due to the addition of Nitrogen.	
CLASSIFICATION	AWS	A 5.4: E 2595-26
	EN ISO	3581-A: E 25 9 4 N L R 32
	DIN: W.Nr.	1.4501

SUITABLE FOR	Welding wrought, forged or cast super duplex stainless steels for service in the as-welded Condition. Heterogeneous welding between super duplex stainless steels and dissimilar welds between other stainless and mild or low alloyed steels. Examples: UNS S32550 :UR 52 N, Ferralium 255, UNS S32520 :UR 52 N+, UNS S32750 :SAF 2507, UR 47 N+, UNS S32760 :ZERON 100, UNS 32760, UR 76 N, SM22Cr, SAF 2507, ASTM S32760 (ZERON 100), S32550 and S31260., It can also be used for welding duplex type 2205, 1.4460, 1.4462,1.4463,1.4515, 1.4517, 1.4507 URANUS 52N, SAF 25.07, GX 3 CrNiMoCuN 26-6-3, (1.4515), GX 3 CrNiMoCuN 26-6-3-3, (1.4517), 25% Cr Super Duplex steels SAF 25/07, S32750 1.4410 - 25Cr-7Ni-4Mo-0.28N SAF2507, NAS74N, S32760 1.4501 - 25Cr-7Ni-3.8Mo-0.7Cu-0.7W-0.25N, S32506 - SUS329J4L 25Cr-7Ni-3Mo-0.15N-0.2W NAS64 1.4507, S31803, S32205,
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APPROVALS	CE approved
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WELDING POSITIONS:



WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Mo	Cu	N	Fe	W
<0.02	1.0-1.2	<0.80	24-26	8-10	2.5-3.5	0.5-0.8	0.15-0.18	Rem	0.5-0.7

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW	>550	>730	>23	50			300-390

AW: as welded

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) DC+/AC	kg / can	kg / 6pack	kg / 1000
2.5	300	60-90	2.5	15	
3.2	350	80-120	2.6	15.6	
4.0	350	100-150	2.8	16.8	

REDRYING TEMPERATURE	if necessary for 2 hr, 300°C (+ / - 10°C)
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