

4501 Kb

CATEGORY	SMAW Stick Electrodes	
TYPE	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. The weld deposit contains Tungsten to fully comply with Zeron 100 Super Duplex steel for improved corrosion resistance. Interpass temperature of <130°C should be respected.	
CLASSIFICATION	AWS	A 5.4: E 2595-15
	EN ISO	3581-A: E 25 9 4 N L B 42
	DIN: W.Nr.	1.4501
	DIN	8556:

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:



TYPICAL DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Mo	Cu	N	Fe	W
<0.03	1.20	0,50	25,00	9,30	3,70	0,70	0,23	Rem	0,60

ALL WELD MECHANICAL PROPERTIES (TYPICAL)

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			FN (WRC)
				20°C	-50°C	-60°C	
AW	660	850	24	70	50	45	55

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	50-75	2.5	15	
3.2	350	70-100	2.6	15.6	
4.0	350	90-150	2.8	16.8	

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