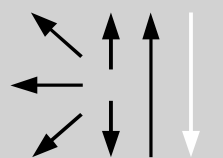


Classifications									
EN ISO 3581-A	AWS A5.4			Mat. No.					
E 25 9 4 N L B 2 2	E2595-15			≈1.4501					
Characteristics and typical fields of application									
<p>Basic coated, core wire alloyed stick electrode designed for welding of superduplex steel and equivalent steel grades. These steels are particularly popular for desalination, pulp & paper, flue gas desulphurization and sea water systems.</p> <p>Resistance to intercrystalline corrosion. Service temperature from - 50 °C up to 220 °C.</p> <p>Very good resistance to pitting corrosion and stress corrosion cracking due to the high CrMo(N) content (pitting index > 40). Well suited for offshore applications.</p>									
Base materials									
1.4515 – GX3CrNiMoCuN26-6-3; 25 % Cr-superduplex steels					1.4517 – GX3CrNiMoCuN26-6-3-3				
Typical analysis of all-weld metal									
	C	Si	Mn	Cr	Mo	Ni	N	Cu	W
wt.-%	0.03	0.5	1.2	25.0	3.7	9.0	0.2	0.7	0.6
Structure: Austenite/ferrit									
Mechanical properties of all-weld metal									
Heat-treatment	Yield strength R _{p0.2}	Yield strength R _{p1.0}	Tensile strength R _m		Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J			
	MPa	MPa	MPa		%	+20 °C -50 °C			
aw	600	650	750		25	70 40			
Operating data									
		Polarity: DC (+)	ø mm		L mm		Amps A		
			2.5		300		55 – 80		
			3.2		350		80 – 105		
			4.0		350		90 – 140		
Welding instruction									
Materials		Preheating				Postweld heat treatment			
Matching / similar steels / cast steel grades		Mostly none. Welding of root pass with “thick layer”. Next two passes with thin layers and low heat input to avoid precipitation and too high ferrite content				Mostly none; if necessary, solution annealing at 1120 °C / water.			