

GETIG 25.10.4L

IDENTIFICATION

GETIG 25.10.4L, 25.9.4L

CLASSIFICATION

AWS/SFA 5.9:ER 25.9.4L

DESCRIPTION

Solid super duplex stainless wire for welding super duplex stainless steels.

CHEMICAL ANALYSIS (RANGE) %

C	Cr	Ni	Mn	Si	S	P	Mo	Cu	N	W
0.03 max	24.0 - 27.0	8.0 - 10.5	2.5 max	1 max	0.02 max	0.035 max	2.5 - 4.5	1.5 max	0.20 - 0.30	1 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
700 - 880	18 - 35	-20°C	45 - 80

TYPICAL APPLICATIONS

Pumps and valves, corrosion / wear resisting parts and process equipment for use in offshore oil and gas industries, pulp, paper and textile industries, and chemical and petrochemical plant.

MATERIALS TO BE WELDED

- SAF 2507, ASTM S-32750, S-32760
- ASTM A351, A744 (cast) - CD4MCu, UNS J93370
- ASTM A240 (wrought) - UNS S32550
- BS 3146 - ANC 21, BS 3100 332C13
- DIN 1.4515, 1.4517
- Steel EN 1.4410, NF 23CND 25-06AZ, SS2328

MICROSTRUCTURE:

In the solution treated condition the micro- structure is duplex with about 30-60% ferrite dependent upon dilution.

INTERPASS TEMPERATURE: 100°C max

HEAT INPUT : 0.5 - 1.5 kJ/mm

SCALING TEMPERATURE: Approx 850°C (air)

CORROSION TEMPERATURE

Very good resistance to pitting and stress corrosion cracking in Chloride containing environments. Pitting resistance in accordance with ASTM G-48A better than 40°C.

PACKING PARAMETERS

GWELD

Size (mm)	Length (mm)	Packing / Pkt (kg)	Packing / Box (kg)
1.6	500 / 1000	5	5 x 4 = 20
2.40 / 2.50	500 / 1000	5	5 x 4 = 20
3.15 / 3.20	500 / 1000	5	5 x 4 = 20
