

# GETIG 25.9.4L

## A SUPER DUPLEX STAINLESS STEEL TIG WIRE

### IDENTIFICATION

Getig 25.9.4L, ER 25.9.4

### CLASSIFICATION

AWS/SFA 5.9: ER 25.9.4

### DESCRIPTION

Getig 25.9.4L is a tig wire designed to match similar alloys. The wire gives matching strength and corrosion resistance in the solution treated condition but can also be used in the as-welded condition. Nitrogen and nickel contents are controlled to give a balanced duplex structure to minimize the risk of cracking, particularly in highly restrained welds.

### CHEMICAL ANALYSIS (RANGE) %

C	Cr	Ni	Mn	Si	W	S	P	Mo	Cu	N
0.03 Max	24.0 - 27.0	8.0 - 10.5	0.5 - 2.50	1 max	1 max	0.02 max	0.03 max	2.5-4.5	1.5 max	0.20 - 0.30

### MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)
760 Min	18 Min

### 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**

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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**

<b>Size (mm)</b>	<b>Length (mm)</b>	<b>Packing / Pkt (kg)</b>	<b>Packing / Box (kg)</b>
1.6	1000	5	5 x 4 = 20
2	1000	5	5 x 4 = 20
2.40 / 2.50	1000	5	5 x 4 = 20
3.15 / 3.20	1000	5	5 x 4 = 20