

GFC 25.9.4

IDENTIFICATION

GFC 25.9.4, E25.9.4T1-1/4

CLASSIFICATION

AWS/SFA 5.22: E25.9.4T1-1/4

DESCRIPTION

GFC 25.9.4 is a rutile type of flux cored wire for all-position welding. It has low spatter generation, easy slag removal and good weld soundness.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Ni	Mo	N	Cu
0.04 max	0.90 max	0.54 max	24.0 - 27.0	8.0 - 10.5	3.5 - 4.5	0.2 - 0.3	0.09 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
760 min	15 min	-20°C	51

TYPICAL APPLICATIONS

GFC 25.9.4 is designed for the welding of 25% Cr, 9% Ni, 4% Mo-Cu super duplex stainless steels and this typical application is chemical plant and shipbuilding as well as nuclear plant industries. (UNS S32750, UNS S32760, S32900).

SPECIAL INSTRUCTIONS:

- The shielding gas should be used 100% CO₂ or (Ar + 20-25% CO₂) for welding;
- Gas flow rate is proper 20-25 l/mn

PACKING PARAMETERS

Size (mm)	Amps DC (+)	Weight / Spool (kg)
1.2	150 - 300	12.5
1.6	200 - 400	12.5