

# GM 25.10.4L

## IDENTIFICATION

GM 25.10.4L, ER 25.9.4

## CLASSIFICATION

AWS/SFA 5.9 : ER 25.9.4

## 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	2.50 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)

EL (%) (L=4D)	CVN Impact Value	
	Temp	Joules
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 microstructure is duplex with about 30-60% ferrite dependent upon dilution.

**INTERPASS TEMPERATURE** : 100°C max

**HEAT INPUT** : 0.5-1.5k l/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**

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<b>Size (mm)</b>	<b>Weight / Spool (kg)</b>
0.8	12.5 / 15.0
1	12.5 / 15.0
1.2	12.5 / 15.0