

GM 25.9.4

IDENTIFICATION

GM 25.9.4, ER 25.9.4

CLASSIFICATION

AWS/SFA 5.9: ER 25.9.4

DESCRIPTION

Solid super duplex stainless wire for welding 2507 type of super duplex stainless steels.

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)	CVN Impact Value	
		Temp	Joules
760 min	15 min	-50°C	60 - 100

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

Size (mm)	Weight / Spool (kg)
0.8	12.5
1	12.5
1.2	12.5
1.6	12.5