Technical data sheet 011121MBA	Cored welding wire # TETRA V D57L-G	Welding Alloys

CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22:	E2594T1-4
EN ISO 17633-A:	T 25 9 4 Cu N L P M21 1
EN ISO 17633-B :	TS2594-F M21 1
UNS Number :	W39594
Equivalent Material Number:	1.4507
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Superduplex stainless steel flux cored wire for gas shielded arc welding.
- Specifically designed for out-of-position welding.
- 25% chromium - 9% nickel - 4% molybdenum - copper - nitrogen - low carbon deposit.
- $PRE_N \geq 40$
- Standard Ar-CO_2 mixtures are used for welding.

APPLICATIONS

TETRA V D57L-G is used for welding superduplex grades and for heterogeneous welding between super duplex stainless steels and other stainless and mild or low alloyed steels.

Examples:

UNS	Material number	EN Symbol
S32520	1.4507	X2 CrNiMoCuN 25-6-3
S32550	1.4507	X2 CrNiMoCuN 25-6-3
S32750	1.4410	X2 CrNiMoN 25-7-4
S32760	1.4501	X2 CrNiMoCuWN 25-7-4

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Cu	N	S	P
0.03	1.40	0.60	25.0	9.40	3.80	1.40	0.24	0.008	0.015

Typical ferrite level: 40 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]
760	550	20	- 20°C: 27

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A_5 [%]	CVN [J]
890	710	24	-20°C: 35

SHIELDING GAS

M21 (Ar + 15 - 25% CO_2) or M20 (Ar + 5 - ≤ 15% CO_2) gas mixtures according to EN ISO 14175

OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow
1.2	DC+	100 - 250	23 - 32	12 - 25	10 - 20 l/min.

WELDING POSITIONS

All positions

PACKAGING

Diameter	1.2 mm	
	EN ISO 544 – ASME IIC SFA-5.2 M	
Spool type	S200	BS300
Weight	5 kg	15 kg

Other packaging and other diameters: please consult us