Technical data sheet EN160823GB	Cored welding wire # TUBE S D57L-S	Welding Alloys

CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22:	EC2594
ASME IIC SFA 5.9 / AWS A 5.9:	EC2594
EN ISO 17633-A:	T 25 9 4 Cu N L M NO 3
EN ISO 17633-B:	TS2594-M NO 0

DESCRIPTION

- Cored superduplex stainless steel wire for submerged arc welding
- 25% chromium - 10% nickel - 4% molybdenum - copper - nitrogen - low carbon weld metal
- Attractive bead appearance without residual slag, outstanding slag release even in narrow gaps
- High productivity and enhanced wetting properties compared to matching solid wires
- Mineral additions to the core improve both mechanical characteristics and resistance to cracking

APPLICATIONS

- Welding wrought, forged or cast superduplex stainless steels
- Superduplex stainless steel cladding or weld overlay

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
S39274		
S39277		
S39553		
	1.4468	GX2 CrNiMoN 25-6-3
	1.4515	GX2 CrNiMoCuN 26-6-3
	1.4517	GX2 CrNiMoCuN 25-6-3-3
S32760	1.4501	X2 CrNiMoCuWN 25-7-4

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Cu	N	S	P
0.02	1.40	0.60	25.5	9.5	3.80	1.00	0.26	0.008	0.015

Typical ferrite level: 40 FN

$PRE_N = Cr + 3.3\ Mo + 16\ N \geq 40$

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A_5 [%]	CVN [J]
760	550	18	+20°C: 40

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]
800	630	23	-20°C: 50

FLUX DESCRIPTION

	WA FLUX 325	WA FLUX 385	WA FLUX 415	WA ULTRAFLUX
EN ISO 14174 class	S A AB 1 65	S A AF 2 64	S A FB 1 55	S A FB 1 55

PACKAGING

Diameter	1.6 mm - 3.2 mm
Standard packaging	EN ISO 544 - ASME IIC SFA-5.2 M
	Coil: B450
Weight	25 kg

Other packaging and other diameters: please consult us