



Selectarc Inox 2509MoB

*Basic Coated Electrode
For Super-Duplex Stainless Steels*

Classification

AWS A5.4 : E2594-15
ISO 3581-A : E 25 9 4 N L B 4 2

EN1600 : E 25 9 4 N L B 4 2

Description & Applications

Basic coated electrode with an austenitic - ferritic microstructure (duplex ~ 40% ferrite). The weld metal can be applied for operation temperatures up to 250°C and is resistant in chloride containing medias against pitting as well as crevice and stress corrosion.

Main applications: For but welding and cladding of steels and castings with an austenitic - ferritic structure, of the same or similar composition, which are used for pumps, vessels , piping systems etc. attacked by chloride containing solutions. But also for impellers and other components which require high strength combined with corrosion attack. Pitting index: > 40.

Base materials

UNS	Alloy	EN 10088	Material N°	CLI
S31803		X2CrNiMoN22-5-3	1.4462	URANUS 45
S32304	35N	X2CrNi23-4	1.4362	URANUS 35N
S32550	52N	G-X2CrNiMoCuN26 6 3	1.4517	URANUS 52N
	52N+	X2CrNiMoCuN25-6-3	1.4507	URANUS 52N+
S32750	2507	X2CrNiMoN25-7-4	1.4410	
S32760	100	X2CrNiMoCuWN25-7-4	1.4501	URANUS 70N
S32900	329	X3CrNiMoN27-5-2	1.4460	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	N	Fe
<0.04	0.5	1.5	25.0	9.5	4.0	0.7	0.23	base

All Weld Metal Mechanical Properties

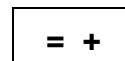
R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
720	850	25	+20°C 70 -40°C 45

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350	5,0x450
Current	(A)	50-75	70-100	90-150	150-190

Redrying 2-3 hours at 250-300°C. Guide electrodes with a slight declination and weld with a short arc. Interpass temperature: <150°C.

FT-en-173-160211



Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.

www.fsh-welding.com - info@fsh-welding.fr