



WELDING

UP 2509

## Classification

AWS A5.9 : ER2594

ISO 14343-A : S 25 9 4 N L

## Description & Applications

Low carbon content solid wire for submerged arc welding of Duplex and Super Duplex (austenitic-ferritic microstructure) type stainless steels. Resistant in chloride containing media against pitting corrosion as well as crevice and stress corrosion. Used for components which require high strength combined with corrosion attack. Could be used with service temperature up to +250°C.

**Main applications:** For pumps, vessels, piping systems.

### Base materials

#### Austenitic-ferritic stainless steels

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

## Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	P	S	Co	W	N	Fe
Min				24.0	8.0	2.5							0.20	
Max	0.03	1.0	2.5	27.0	10.5	4.5	1.5	-	0.03	0.02	-	1.0	0.30	Rem.
Type	0.012	0.50	0.60	25.5	9.2	4.0	0.10	0.01	0.02	0.01	0.05	0.05	0.25	Rem.

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters				Flux
		Current (A)	Voltage (V)	Stick out (mm)	Speed (cm/min)	
SAW = +	2.4	340 - 380	28 - 29	18	48 - 60	UP WP380M
	3.2	360 - 430	28 - 29	20	48 - 60	
	4.0	450 - 550	28 - 30	22	50 - 60	

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