

Applications

- ① used for welding of 25%Cr-7%Ni-4.5%Mo-0.25%N Super Duplex steel.
- ② used for welding of Petochemical plants, offshore structures and FPSO.

Characteristics on Usage

- ① Weld metal has 30~60% ferrite contents
- ② Due to the high chromium contents, corrosion resistance is excellent in most environments (chloride environment)
- ③ Superior pitting resistance(PREN ≥40)

Typical Chemical Composition of Wire (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	N
0.011	0.41	0.53	0.019	0.001	25.27	9.13	3.86	0.21	0.257

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)	PREN
890 (129,000)	28.6	-50 (-58)	195 (144)	40

Ferrite Contents of All-Weld Metal(Shielding gas : 100%Ar)

	WRC-1992 (FN)	Shaeffler Diagram(%)
As welded	66.9	80.3

Typical Welding Conditions (DC-)

Size mm(in)	Currents A	Gas Flow (ℓ /min.)	Shielding gas
1.2 (.045) ~ 2.0 (5/64)	50 ~ 100	25	Ar
1.6 (1/16) ~ 3.2 (1/8)	100 ~ 200		
2.4 (3/32) ~ 3.2 (1/8)	200 ~ 300		
3.2 (1/8)	300 ~ 400		

Approval

I Packing

ABS