

Classifications

EN ISO 14343-A	EN ISO 14343-B	ASME II C SFA 5.9
B Z 25 8 4 N L	BS(2594)	(EQ2594)

Characteristics and typical fields of application

SOUDOTAPE 25.8.4L is a strip electrode developed for Electroslag Strip Cladding of super duplex stainless steel (UNS designations S32750).

In combination with fluoride basic flux RECORD ES 2507, this strip electrode SOUDOTAPE 25.8.4L will produce single layer weld deposit that met the requirement for 2594 super-duplex stainless steel designation.

High pitting corrosion resistance PREN > 40

Highly suitable for service in environments containing chlorides and hydrogen sulfide, such as marine environments and the oil and gas extraction industry, the pulp and paper industry, and heat exchangers.

Typical analysis

	C	Si	Mn	Cr	Ni	Mo	N	Fe	Cu
wt.-%	0.015	0.4	0.7	25.5	7.1	4.0	0.27	Rem.	0.3

Typical fluxes to combine

Process	Name	EN ISO 14174
ESW	RECORD ES 2507	ES A FB 2B