Thermanit 25/09 CuT

SAW wire, high-alloyed, superduplex stainless

Classifications

EN ISO 14343-A	AWS A5.9 / SFA-5.9
S 25 9 4 N L	ER2594

Characteristics and typical fields of application

Solid wire for submerged arc welding of super duplex stainless steel grades such as such as 1.4410 / UNS S32570, 1.4507 / UNS S32550 and 1.4501 / UNS S32760. Solid wire of S 25 9 4 N L / ER2594 type. Resistant to intercrystalline corrosion. The weld metal shows excellent resistance to pitting and crevice corrosion in chlorine containing media as well as to stress corrosion cracking especially in H_2S containing media. Well-suited for the conditions in the offshore field. Application temperature is –50ºC up to 220ºC.

Recommended SAW flux:
Marathon 431

Base materials

1.4501 – X2CrNiMoCuN25-7-4 – UNS S32760
1.4515 – GX3CrNiMoCuN26-6-3
1.4517 – GX3CrNiMoCuN25-6-3-3
25%ige Cr-Superduplex steels UNS S32760 such as Zeron 100,
SAF 25/07, FALC 100, NIROSTA ® 4501

Typical analysis

	C	Si	Mn	Cr	Ni	Mo	W	N	Cu	PRE_N
wt.-%	0.015	0.40	0.90	26.0	9.5	3.8	0.6	0.23	0.6	>40

Structure: Austenite/ferrite

Operating data

Dimension mm
2.0
2.4
3.2

No preheating. Suggested heat input max. 1.5 kJ/mm, interpass temperature max. 120ºC.
Post-weld heat treatment generally not needed. In special cases, solution annealing can be performed at 1100 – 1150ºC followed by water quenching.

Approvals

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