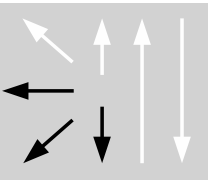


Classification									
SAW solid wire:		SAW flux:							
<b>EN ISO 14343-A</b>	<b>AWS A5.9</b>	<b>EN ISO 14174</b>							
S 25 9 4 N L	ER2594	SA FB 2 DC							
Characteristics and typical fields of application									
<p><b>Thermanit 25/09 CuT / Marathon 431</b> is a wire/flux combination for submerged arc welding of super duplex stainless steel grades like SAF 2507, ASTM S32760, S32550 and S31260. 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<sub>2</sub>S containing media. Suitable for service temperatures from -40 °C to +220 °C.</p> <p><b>Marathon 431</b> is an agglomerated basic flux that ensures good welding properties with nice bead appearance and good slag detachability. For more information regarding this sub-arc welding flux see our detailed data sheet.</p>									
Base materials									
Super-duplex steels such as: UNS No. S 32570, S 31260, S 32570, S 32760 etc.									
Typical analysis of the wire and of all-weld metal (wt.-%)									
	C	Si	Mn	Cr	Ni	Mo	N	Cu	W
Wire	0.015	0.40	1.0	25.5	9.5	3.8	0.22	0.5	0.6
Weld metal	0.02	0.50	0.8	25.0	9.5	3.8	0.22	0.5	0.6
Mechanical properties of all-weld metal									
Heat-treatment	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V CVN J					
	MPa	MPa	%	-46 °C					
aw	650	870	>20	>45					
Operating data									
	<b>Polarity:</b> DC+	Preheating: None Interpass temp.: ≤ 120 °C Heat Input: < 1.5kJ/mm PWHT (if required): approx. 1130 °C / water quenching							
Approvals									
ABS, DNV, BV									