

### DESCRIPTION

Basic electrode with an austenitic-ferritic microstructure (duplex ~40% ferrite). The weld metal can be applied for operation temperatures up to 250°C and is resistant in chloride containing medias against pitting as well as crevice and stress corrosion. For but welding and cladding of steels and castings with an austenitic - ferritic structure, of the same or similar composition, which are used for pumps, vessels, piping systems etc., attacked by chloride solution. But also for impellers and other components which require high strength combined with corrosion attack. Pitting index > 40.

### CLASSIFICATION

AWS A 5.4 : E 2595-15      EN 1600 : E 25 9 4 N L B 42      ISO 3581-A : E 25 9 4 N L B 42

### TYPICAL APPLICATIONS

Tanks, pumps, piping systems...

### BASE MATERIALS

UNS	Alloy	EN 10088	Material N°	CLI
S31803		X2CrNiMoN22-5-3	1.4462	URANUS 45
S32304	35N	X2CrNi23-4	1.4362	URANUS 35N
S32550	52N	G-2CrNiMoCuN26 6 3	1.4517	URANUS 52N
	52N+	X2CrNiMoCuN25-6-3	1.4507	URANUS 52N+
S32760	100	X2CrNiMoCuW25 7 4	1.4501	URANUS 70N
S32900	329	X3CrNiMoN27-5-2	1.4460	

### PROCEDURE

Rebaking 2-3 hours at 250-300°C. Interpass temperature : < 170°C.

### MECHANICAL PROPERTIES

Tensile strength: 130 533 psi (900 MPa)  
 Yield strength: 101 526 psi (700 MPa)  
 Elongation: 24 %  
 Impact (Charpy V): 75 J at +20°C and 50 J at -50°C

### TYPICAL WELD METAL COMPOSITION (%)

C	Mn	Si	Cr	Ni	Mo	N	W	Cu	Fe
0.04	1.5	0.5	25.0	9.3	3.6	0.23	0.5	0.7	Rem

### WELDING PARAMETERS

Diameter: 4.0 mm (5/32")      3.2 mm (1/8")      2.5 mm (3/32")  
 Amperage: 90-150 A      70-100 A      50-75 A

### WELDING POSITIONS



1G/PA

2F/PB

2G/PC

3G/PF

4G/PE

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*Specialized welding alloys and technology. For technical assistance or for ordering:*