



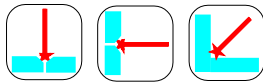
Super-Duplex XT

AWS A 5.9: ER2594 ISO 14343-A: W 25 9 4 N L

DESCRIPTION

Stainless steel alloy for welding super-duplex grades. Heterogeneous welding between superduplex stainless steels and other stainless and mild or low alloyed steels.

WELDING POSITIONS



CURRENT

DC-

GAS

Ar(l1)

BASE MATERIAL

1.4507, 1.4410, 1.4468, 1.4515, 1.4517, 1.4501

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>
820	630	25	+20°C – 130 -40°C – 90

WELD METAL COMPOSITION(%)

C	Mn	Si	Cr	Mo	Ni
0.02	0,4	0,3	25,0	4,0	10,0

PACKAGING

Dimension(mm)	1,2	1,6	2,0	2,4	3,2
Hylsa (kg)	5	5	5	5	5
Artikel nummer	9M251LS121	9M251LS161	9M251LS201	9M251LS241	9M251LS321

EQUIVALENT FILLER METALS

MMA	Meltolit Super-Duplex E
MIG	Meltolit Super-Duplex XM
FCW	Meltolit Super-Duplex FCW