

BETANOX 2595-15

AWS A/SFA 5.4 E2595-15

STAINLESS STEEL (Duplex SS)

CLASSIFICATION:

ISO 3581-A
E 25 9 4 N L B 22

KEY FEATURES:

- Basic type non-synthetic coating
- Super duplex SS deposit
- High strength and freedom from weld cracking in highly restrained joints
- Presence of Tungsten ensures highest resistance to hot cracking
- Improved resistance against pitting, chemical attack and chloride environment e.g. sea water
- Low spatter losses
- Easy slag detachability
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of super duplex stainless steels such as UNS S32550, S32750, S32760 (wrought) and UNS J93370, J93380, J93404, CD4MCuN (cast)
- Can be used to weld standard duplex stainless steel such as UNS S31803 and UNS S32205, carbon and low alloy steels to duplex steels as well

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


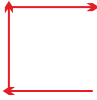
C	Mn	Si	Cr	Ni	Mo	N	W
0.03	1.0	0.9	25.5	9.9	4.0	0.25	1.1

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%	Ferrite No.	PREN
Typical	As Welded	840	28	54	55
Specification		760 min	15 min	40-60	40 min

Special Tests: Meets Pitting Corrosion Resistance at 25°C and 30°C as per ASTM G-48

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.0 x 300	50-80	 DCEP	All Positions, except vertical Downwards
2.5 x 350	70-110		
3.15 x 350	90-140		
4.0 x 350	140-180		
		REDRYING CONDITION: 250-300°C for minimum 1 hr.	

Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kgs each.