



BETANOX 2595-15

STAINLESS STEEL (Duplex SS)



Basic type Electrode for Welding super duplex stainless steels

CLASSIFICATION : ISO 3581-A

AWS A/SFA 5.4

E 25 9 4 N L B 22

E 2595-15

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

WELDING POSITION :



DCEP

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

REDRYING CONDITION : 250-300°C for minimum 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni	Mo
Typical	0.03	1.4	0.7	25.6	9.4	3.6
Specification	0.04 max	2.5 max	1.2 max	24-27	8.0-10.5	2.5-4.5
	W	Cu	N	S	P	W
Typical	0.6	0.9	0.24	0.02	0.02	-
Specification	0.40-1.0	0.40-1.5	0.2-0.3	0.025 max	0.03 max	0.4-1.0

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%	Ferrite No.	PREN
Typical	As Welded	840	28	53	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	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.0 x 300	50-80	2	5	10
2.5 x 350	70-110	2	5	10
3.15 x 350	90-140	2	5	10
4.0 x 350	130-180	2	5	10