OK Tigrod 2509

Bare corrosion resisting "Super Duplex" rods for welding of austenitic-ferritic stainless alloys of 25% Cr, 7% Ni , 4%Mo, low C types. OK Tigrod 2509 has high intergranular, pitting and stress corrosion resistance. The alloy is widely used in applications were corrosion resistance is of outmost importance. Pulp & paper industry, offshore and gas industry are areas of interest.

Specifications	
Classifications	EN ISO 14343-A : W 25 9 4 N L SFA/AWS A5.9 : ER2594
Approvals	CE : EN 13479 UKCA : EN 13479 VdTÜV : 06593

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic-ferritic (25 % Cr - 10 % Ni - 4 % Mo - Low C)
Shielding Gas	I1, I3, N2 (EN ISO 14175)

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
As Welded	660 MPa	835 MPa	37 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
As Welded	-20 °C	200 J
As Welded	-50 °C	180 J

Typical Weld Metal Analysis %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**N**
0.013	0.7	0.4	0.002	0.016	9.3	24.9	3.8	0.07	0.23

Typical Weld Metal Analysis %		
PRE	**FN WRC-92**	**W**
41	60	0.002

Typical Wire Composition %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**N**
0.01	0.4	0.4	0.010	0.015	9.4	25.2	3.9	0.1	0.24

Typical Wire Composition %	
PRE	**FN WRC-92**
42	50