

Standards

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| TS EN ISO 3581-A | : E 25 9 4 N L B 42 |
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| AWS A5.4 | : E 2594 - 15 |

**Chemical Composition of
Weld Metal % (Typical)**

| C | Si | Mn | Mo | Ni | Cr | N |
|-------|------|------|-----|-----|------|------|
| 0.035 | 0.35 | 1.45 | 3.8 | 8.6 | 24.0 | 0.25 |

Mechanical Properties

| Yield Strength (N/mm ²) | Tensile Strength (N/mm ²) | Impact Strength (ISO-V/+20°C) | Elongation (L ₀ =5d ₀) (%) |
|--|--|----------------------------------|--|
| min. 550 | min. 760 | min. 47 J | min. 18 |

Typical Base Material Grades

- 1.4410, X2CrNiMoN 25-7-4, 1.4501, X2CrNiMoCuWN 25-7-4, 1.4507, X2CrNiMoCuN 25-6-3
- UNS S32750, S32760, S32550

Features and Applications

- Basic type electrode which used especially for the welding of duplex steels. It provides high yield and tensile strength and the weld metal is resistant to pitting corrosion
- Re-drying: 250°C - 300°C / min. 2h

Welding Positions

Current Type

D.C.(+)

Operating Data

| Product Code | Diameter x Length (mm) / (inch) | | Welding Current (A) | Weight g / 100 pcs |
|--------------|------------------------------------|------------|------------------------|-----------------------|
| | | | | |
| 3010101573 | 2.50 x 250 | 3/32 x 10" | 60 - 80 | 1470 |
| 3010101578 | 3.20 x 300 | 1/8 x 12" | 80 - 120 | 2870 |

Approvals: CE, SEPRO