

2507**TIG (GTAW)****SOLID WELDING WIRE FOR SUPERDUPLEX STEELS****PRODUCT DESCRIPTION**

Solid wire for TIG

CLASSIFICATIONS

AWS A5.9M ER2594
ISO 14343-A W 25 9 4 N L

ASME IX QUALIFICATION

QW432 F-No 6
QW442 A-No --

COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	W	Cu	N	PRE _N
Min.	--	--	--	--	--	24.0	8.0	3.0	--	--	0.20	40
Max.	0.03	2.5	1.0	0.02	0.03	27.0	10.5	4.5	0.5	0.5	0.30	--
Typical	0.02	0.8	0.4	0.005	0.02	25	9.3	3.9	0.05	0.05	0.25	42

ALL-WELD MECHANICAL PROPERTIES WITHZERON® 100X WIRE

As welded	Min.	Typical
Tensile strength (MPa)	760	870
0.2% proof strength (MPa)	550	695
Elongation (%) 4d	15	36
5d	20	32
Reduction of area (%)	--	68
Impact ISO-V[J] - 50°C	--	130
Hardness cap/mid (HV)	--	300

TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Parameters
Argon	DC-	1.6 / 2.4	100A, 12V

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.6	2.5	PE TUBE	T2507-16
2.0	2.5	PE TUBE	T2507-20
2.4	2.5	PE TUBE	T2507-24

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.specialalloys.eu for any updated information.