

Technical data sheet

011121MBA

Cored welding wire
TETRA S D57L-G**CLASSIFICATION**

ASME IIC SFA 5.22 / AWS A 5.22:	E2594T0-4
EN ISO 17633-A:	T 25 9 4 Cu N L R M21 3
Equivalent Material number:	1.4507
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Special flux cored super duplex stainless steel wire for gas shielded arc welding
- 25% chromium - 9% nickel - 4% molybdenum - copper - nitrogen - low carbon deposit
- Attractive bead appearance, very good penetration profile, high productivity
- Excellent weld metal quality and X-ray soundness
- Maximum performances in the flat and horizontal positions
- Classical economical Ar-CO₂ mixtures are used for welding

APPLICATIONS

- Welding superduplex grades.
- Heterogeneous welding between superduplex stainless steels and other stainless and mild or low alloyed steels.

Examples:

UNS	Material number	EN Symbol
S32520	1.4507	X2 CrNiMoCuN 25-6-3
S32550	1.4507	X2 CrNiMoCuN 25-6-3
S32750	1.4410	X2 CrNiMoN 25-7-4
S39274		
S39277		
S39553		
	1.4468	GX2 CrNiMoN 25-6-3
	1.4515	GX2 CrNiMoCuN 26-6-3
	1.4517	GX2 CrNiMoCuN 25-6-3-3
S32760	1.4501	X2 CrNiMoCuWN 25-7-4

APPROVALS

TÜV (09440.04)

TYPICAL ALL-WELD METAL ANALYSIS

C	Si	Mn	Cr	Ni	Mo	Cu	N
0.03	0.5	1.0	25.5	9	3.8	1.1	0.24

Typical ferrite level: 35 - 50 FN

PRE_N = Cr + 3.3 Mo + 16 N ≥ 40**MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES**

Rm [MPa]	Rp0.2% [MPa]	As [%]	KV [J]
760	550	18	-20°C: 27

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	KV [J]
920	730	22	-20°C: 35

SHIELDING GASEN ISO 14175: M21 (Ar + 15 - 25% CO₂)**OPERATING CONDITIONS**

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow
1.2	DC+	130 - 250	24 - 35	12 - 25	10 - 20 l/min.
1.6	DC+	150 - 300	24 - 35	12 - 25	10 - 20 l/min.

WELDING POSITIONS

Flat, horizontal

PACKAGING

Diameter	1.2 mm		1.6 mm
	EN ISO 544 – ASME II C SFA-5.2 M		
Spool type	S200	BS300	BS300
Weight	5 kg	15 kg	15 kg

Other packaging and other diameters: please consult us

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