

Technical data sheet

011121MBA

**Cored welding wire
TETRA S D750-G****CLASSIFICATION**

ASME IIC SFA 5.22 / AWS A 5.22:	E2594T0-4
EN ISO 17633-A:	T 25 9 4 N L R M21 3
EN ISO 17633-B:	TS2594-F M21 0
UNS Number:	W39594
Equivalent Material Number:	1.4410
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Super duplex stainless steel wire for gas shielded arc welding
- 25% chromium - 10% nickel - 4% molybdenum - low carbon - high nitrogen bearing deposit
- PRE_N ≥ 40
- Attractive bead appearance, very good penetration profile, high productivity
- Excellent weld metal quality and X-ray soundness
- Maximum performance in the flat and horizontal positions
- Classical economic Ar-CO₂ mixtures are used for welding

APPLICATIONS

- Welding superduplex stainless steels.
- 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

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	N	S	P
0.03	1.0	0.8	25.2	9.5	4.0	0.28	0.008	0.015

Typical ferrite level: 40 FN

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

Rm [MPa]	Rp0.2%[MPa]	A ₅ [%]	CVN [J]
760	550	20	+20°C: 40

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A ₅ [%]	CVN [J]
875	715	23	-20°C: 32

SHIELDING GASM21 (Ar + 15 - 25% CO₂) gas mixtures according to EN ISO 14175**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 IIC SFA-5.2 M		
Spool type	S200	BS300	BS300
Weight	5 kg	15 kg	15 kg

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.