

Technical data sheet

011121MBA

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

ASME IIC SFA 5.22 / AWS A 5.22:	E2594T1-4
EN ISO 17633-A:	T 25 9 4 N L P M21 1
EN ISO 17633-B :	TS2594-F M21 1
UNS Number :	W39594
Equivalent Material Number:	1.4410
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Superduplex stainless steel flux cored wire for gas shielded arc welding.
- Specifically designed for out-of-position welding.
- 25% chromium - 9% nickel - 4% molybdenum - low carbon - high nitrogen bearing deposit.
- $PRE_N \geq 40$
- Standard Ar-CO₂ mixtures are used for welding.

APPLICATIONS

TETRA V D750-G is used for welding superduplex grades and for heterogeneous welding between super duplex 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
S32760	1.4501	X2 CrNiMoCuWN 25-7-4

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	N	S	P
0.03	1.40	0.60	25.0	9.40	3.80	0.27	0.008	0.015

Typical ferrite level: 40 FN

$PRE_N = \%Cr + 3.3 \%Mo + 16 \%N \geq 40$

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A ₅ [%]	CVN [J]
760	550	20	-20°C: 32

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A ₅ [%]	CVN [J]
880	710	23	-20°C: 40

SHIELDING GAS

M21 (Ar + 15 - 25% CO₂) or M20 (Ar + 5 - ≤ 15% 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 (+)	100 - 250	23 - 32	12 - 25	10 - 20 l/min.

WELDING POSITIONS

All positions

PACKAGING

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