

**Technical data sheet**

011121MBA

**Cored welding wire  
TETRA V D760-G****CLASSIFICATION**

ASME IIC SFA 5.22 / AWS A 5.22:	E2594T1-4
EN ISO 17633-A:	T Z 25 9 4 Cu W N L P M21 1
EN ISO 17633-B:	TS2594-F M21 1
UNS Number:	W39594
Equivalent Material number:	1.4501
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 - copper - tungsten - nitrogen - low carbon deposit
- PRE<sub>N</sub> ≥ 40
- Standard Ar-CO<sub>2</sub> mixtures are used for welding.

**APPLICATIONS**

TETRA V D760-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	Cu	W	N	S	P
0.03	1.20	0.60	25.0	9.40	3.80	0.6	0.6	0.27	0.008	0.015

Typical ferrite level: 40 FN  
PRE<sub>N</sub> = Cr + 3.3 Mo + 16 N ≥ 40

**MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES**

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

**TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES**

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
880	710	24	-20°C: 40

**SHIELDING GAS**

M21 (Ar + 15 - 25% CO<sub>2</sub>) or M20 (Ar + 5% < CO<sub>2</sub> ≤ 15%) 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 IIC 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.