


Technical data sheet <small>011121MBA</small>	Coated SMAW Electrode WA TETRA B D57L-E	
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CLASSIFICATION

ASME IIC SFA 5.4 / AWS A 5.4: E2594-15
EN ISO 3581-A: E 25 9 4 N L B 4 2

DESCRIPTION

- Basic coated electrode for welding superduplex stainless steel
- Super-duplex deposit type 25 9 4
- Welding of superduplex and duplex alloys
- Complements Welding Alloys cored wires TETRA S D57L-G and TETRA V D57L-G

APPLICATIONS

- Welding super duplex grades in when high impact toughness is required.
- 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
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	Cu	N	Fe
0.04	1.5	10.5	25.0	9.5	4.0	0.7	0.23	Bal.

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	As [%]	CVN [J]
800	700	22	+20°C: 50

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	As [%]	CVN [J]
880	750	24	+20°C: 85

OPERATING CONDITIONS

Electrode Ø x L [mm]	2.5 x 300	3.2 x 350	4.0 x 350
Current [A]	65	100	130
= +	~ 70V		

Re-drying if necessary 1h at 250°C.

WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PF, PE
ASME IX: 1G, 2F, 2G, 3G, 4G

PACKAGING

Electrode Ø x L [mm]	2.5 x 300	3.2 x 350	4.0 x 350
Weight / box [kg]	5	5	5

Other packaging and other sizes: 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.