

OK Tigrod 2509

GTAW
W 25 9 4 NL

Description

Bare, corrosion-resistant, "Super Duplex" rods for welding austenitic-ferritic stainless alloys of the 25% Cr, 7% Ni, 4% Mo, low C types. OK Autrod 2509 has high intergranular-corrosion, pitting and stress-corrosion resistance. The alloy is widely used in applications where corrosion resistance is of the utmost importance. The pulp & paper industry, offshore and gas industry are areas of interest.

Welding current

DC(-)

Classifications

EN 12072 W 25 9 4 NL

Wire composition

C	Si	Mn	Cr	Ni	Mo	W	Cu
<0.02	0.4	0.4	25.0	9.8	4.0	<1.0	<0.3

Typical mech. properties all weld metal

Yield stress, MPa	670
Tensile strength, MPa	850
Elongation, %	30

Charpy V

Test temps, °C	Impact values, J
+20	150
-40	115

Approvals

UDT DIN 8556
VdTÜV

Packing data

Diameter, mm	Length, mm	Weight of rods/ box, kg
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0