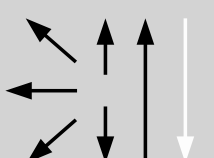


Classifications										
EN ISO 3581-A			AWS A5.4			Mat. No.				
E 25 9 4 N L B 2 2			E2595-15			≈1.4501				
Characteristics and typical fields of application										
Stainless. Resistance to intercrystalline corrosion – wet corrosion up to 250 °C (482 °F). Very good resistance to pitting corrosion and stress corrosion cracking due to the high CrMo(N) content (pitting index > 40). Well suited for offshore applications.										
Base materials										
1.4515 – GX3CrNiMoCuN26-6-3; 25 % Cr-superduplex steels										
1.4517 – GX3CrNiMoCuN26-6-3-3										
Typical analysis of all-weld metal (wt.-%)										
	C	Si	Mn	Cr	Mo	Ni	N	Cu	W	
wt-%	0.03	0.5	1.2	25.0	3.7	9.0	0.2	0.7	0.6	
Structure: Austenite/ferrit										
Mechanical properties of all-weld metal										
Heat-treatment	Yield strength R _{p0.2}		Yield strength R _{p1.0}		Tensile strength R _m		Elongation A (L ₀ =5d ₀)		Impact work ISO-V KV J	
	MPa		MPa		MPa		%		+20 °C –50 °C	
aw	600		650		750		25		70 50	
Operating data										
			Polarity: DC (+)		ø (mm)		L mm		Amps A	
					2.5		300		55 – 80	
					3.2		350		80 – 105	
					4.0		350		90 – 140	
Welding instruction										
Materials			Preheating				Postweld heat treatment			
Matching / similar steels / cast steel grades			Mostly none. Welding of root pass with “thick layer”. Next two passes with thin layers and low heat input to avoid precipitation and too high ferrite content				Mostly none; if necessary, solution annealing at 1120 °C / water.			