



BETANOX 2595-15

STAINLESS STEEL (Duplex SS)

AWS A/SFA 5.4 **E2595-15**

CLASSIFICATION:

ISO 3581-A
E 25 9 4 N L B 22

KEY FEATURES:

- Basic type non-synthetic coating
- Super duplex SS deposit
- High strength and freedom from weld cracking in highly restrained joints
- Presence of Tungsten ensures highest resistance to hot cracking
- Improved resistance against pitting, chemical attack and chloride environment e.g. sea water
- Low spatter losses
- Easy slag detachability
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of super duplex stainless steels such as UNS S32550, S32750, S32760 (wrought) and UNS J93370, J93380, J93404, CD4MCuN (cast)
- Can be used to weld standard duplex stainless steel such as UNS S31803 and UNS S32205, carbon and low alloy steels to duplex steels as well

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Mo	N	W
0.03	1.0	0.9	25.5	9.9	4.0	0.25	1.1



MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	840	28	54
Specification		760 min	15 min	40-60

Special Tests: Meets Pitting Corrosion Resistance at 25°C and 30°C as per ASTM G-48

PREN: 40 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	50-80	 DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
3.15 x 350	70-110		
4.0 x 350	90-140		

Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kg each.