



# BETANOX 2595-16

STAINLESS STEEL (Duplex SS)

AWS A/SFA 5.4 **E2595-16**

### CLASSIFICATION:

ISO 3581-A  
E 25 9 4 N L R 12

### KEY FEATURES:

- Rutile type non-synthetic coating
- Super duplex SS weld deposit
- Resistant to pitting, chemical attack and chloride containing media
- Tungsten provides resistance against hot cracking
- Ni and N ensures good toughness properties and freedom from weld cracking in highly restrained joints
- Easy slag detachability
- Suitable for all position
- 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
0.02	0.6	0.7	26	9.5	3.9	0.23	1.0


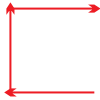
### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	835	27	50
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	 <b>AC (70 OCV) /DCEP</b> <b>REDRYING CONDITION:</b> 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.