

## OK Tigrod 2509

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

### Specifications

<b>Classifications</b>	EN ISO 14343-A : W 25 9 4 N L SFA/AWS A5.9 : ER2594
<b>Approvals</b>	CE : EN 13479 NAKS/HAKC : 2.0 - 2.4 mm UKCA : EN 13479 VdTÜV : 06593

Approvals are based on factory location. Please contact ESAB for more information.

<b>Alloy Type</b>	Austenitic-ferritic (25 % Cr - 10 % Ni - 4 % Mo - Low C)
<b>Shielding Gas</b>	I1, I3, N2 (EN ISO 14175)

### Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
As Welded	660 MPa	835 MPa	37 %

### Charpy Testing

Testing Condition	Testing Temp	Impact Value
As Welded	-20 °C	200 J
As Welded	-50 °C	180 J

### Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	N	PRE	FN WRC-92
0.01	0.4	0.4	9.4	25.2	3.9	0.24	42	50