

OK Autrod 2509

A continuous solid corrosion resisting "Super Duplex" wire for welding of austenitic-ferritic stainless alloys of 25% Cr, 10% Ni, 4% Mo, low C types. OK Autrod 2509 has a high intergranular corrosion resistance and pitting. 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. OK Autrod 2509 can be used in combination with OK Flux 10.93 or OK Flux 10.94.

Specifications

Classifications	EN ISO 14343-A : S 25 9 4 N L SFA/AWS A5.9 : ER2594
Approvals	CE : EN 13479 UKCA : EN 13479 VdTÜV : 12101

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

Alloy Type	Austenitic-ferritic (25% Cr - 10% Ni - 4% Mo - Low C)
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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