

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 utmost importance. Pulp & paper industry, offshore and gas industry are areas of interest.

Specifications

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|------------------------|---|
| Classifications | EN ISO 14343-A : W 25 9 4 N L SFA/AWS A5.9 : ER2594 |
| Approvals | 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.

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

Typical Tensile Properties

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

Typical Charpy V-Notch Properties

| Condition | Testing Temperature | 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 |