

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	
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.

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