

Classifications									
EN ISO 14343-A	AWS A5.9			Mat. No.					
G 25 9 4 N L	ER2594			≈1.4501					
Characteristics and typical fields of application									
<p>Stainless; resistant to intercrystalline corrosion (Application temp.: -50 °C (-58 °F) up to 220 °C (48 °F). Very good resistance to pitting corrosion and stress corrosion cracking due to the high CrMo(N) content (pitting index ≥ 40).</p> <p>Well suited for the conditions in the offshore field.</p>									
Base materials									
<p>1.4501 – X2CrNiMoCuN25-7-4 – UNS S32760 1.4515 – GX3CrNiMoCuN26-6-3 1.4517 – GX3CrNiMoCuN25-6-3-3 25 %ige Cr-Superduplex steels UNS S32760 such as Zeron 100, SAF 25/07, FALC 100, NIROSTA® 4501</p>									
Typical analysis of solid wire (wt.-%)									
	C	Si	Mn	Cr	Mo	Ni	N	Cu	W
wt-%	0.02	0.3	1.5	25.5	3.7	9.5	0.22	0.8	0.6
Structure: Austenite/ferrite									
Mechanical properties of all-weld metal									
Heat-treatment	Yield strength R _{p0.2}	Yield strength R _{p1.0}	Tensile strength R _m		Elongation A (L ₀ =5d ₀)		Impact work ISO-V KV J		
	MPa	MPa	MPa		%		+20 °C		-46 °C
aw	650	700	750		25		80		50
Operating data									
Polarity: DC (+)		Shielding gas: (EN ISO 14175) M12, M13			ø (mm) 1.0 1.2 1.6		Spool: B300 B300 B300		
Welding instruction									
Materials			Preheating		Postweld heat treatment				
Matching / similar steels / cast steel grades			Mostly none		Mostly none; if necessary, solution annealing at 1120 °C (2048 °F) / water.				