

ZERON® 100X

TIG (GTAW)

SOLID WELDING WIRE FOR SUPERDUPLEX STEELS

PRODUCT DESCRIPTION

Solid wire for TIG welding.

For applications where Zeron® 100X wire is to be used for welding supermartensitic stainless steels it is possible for wire to be supplied with a total hydrogen content of 3ppm maximum.

CLASSIFICATIONS

AWS A5.9M	ER2594
ISO 14343-A	W 25 9 4 N L
Weir Materials	MDS 12809/07
Approvals	ABS, TÜV, DNV

ASME IX QUALIFICATION

QW432	F-No 6
QW442	A-No 8

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	W	Cu	N	PRE _N	PRE _W
Min.	--	--	--	--	--	24.0	9.0	3.5	0.5	0.5	0.2	40	40
Max.	0.03	1.0	1.0	0.01	0.03	26.0	10.0	4.0	1.0	1.0	0.3	--	--
Typical	0.015	0.7	0.4	0.002	0.02	25	9.3	3.7	0.6	0.7	0.23	41	42

ALL-WELD MECHANICAL PROPERTIES

Typical values as welded	Min.	TIG	TIG at 160°C
Tensile strength (MPa)	760	870	769
0.2% proof strength (MPa)	550	695	523
Elongation (%) 4d	15	36	39
5d	20	32	34
Reduction of area (%)	--	68	72
Impact ISO-V(J) -50°C	--	130	--
-75°C	--	>100	--
Hardness cap/mid (HV)	--	290	--

TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Parameters
Argon	DC-	1.6 / 2.4	100A, 12V

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.6	2.5	PE TUBE	TZ100X-16
2.0	2.5	PE TUBE	TZ100X-20
2.4	2.5	PE TUBE	TZ100X-24
3.2	2.5	PE TUBE	TZ100X-32

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.specialalloys.eu for any updated information.