LNM Zeron 100X

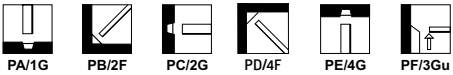
CLASSIFICATION

AWS A5.9 - ER2594
ISO 14343-A - G 25 9 4 N L

GENERAL DESCRIPTION

Solid wire for welding Zeron 100® and other super duplex stainless steel grades
High resistance to pitting and crevice corrosion in seawater

WELDING POSITIONS (ISO/ASME)



SHIELDING GASES (ACC. ISO 14175)

M12	Mixed gas Ar+ 0.5-5% CO_2
M13	Mixed gas Ar+ 0.5-3% O_2

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Ni	Mo	Cu	W	N
0.015	0.7	0.3	25	9.8	3.6	0.6	0.7	0.22

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	0.2% proof strength (N/mm²)	Tensile strength (N/mm²)	Elongation (%)	Impact ISO-V(J) -50°C
Typical values	M12	AW	645	860	23	60

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	Mat. Nr	UNS		
Regular and super duplex stainless steels					
	X2CrNiMoN25-7-4		1.4410		
	X4CrNiMoN27-5-2		1.4460		
	X2CrNiMoN22-5-3		1.4462	2205	S31803
		G-X6CrNiMo24-8-2	1.4463		
				CD-4MCu	S32550
				Zeron 100	S32760

Super duplex stainless steel grades: chemical composition approximately:
24-27% Cr, 6-9% Ni, 3-4% Mo, 0.10-0.25% N alloyed also with Cu and/or W

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.0	1.2
Unit : 12.5 kg spool S300	X	X

Other sizes and packaging on request