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% CO₂
M13 Mixed gas Ar+ 0.5-3% O₃

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		0.2% proof strength	Tensile strength	Elongation	Impact ISO-V(J)
	gas	Condition	(N/mm²)	(N/mm²)	[%]	-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	r 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

D	1.0	1.2			
Unit:	12.5 kg spool S300	Х	Х		
Other sizes and packaging on request					

LNM Zeron100X: rev. EN 26



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