



AWS A5.9: ER2594  
ISO 14343-A-2009 25 9 4 N L

# Super Duplex Solid Wire

## MIG/TIG Welding

### SW-4501

#### DESCRIPTION & APPLICATION

MIG/TIG Filler wire for the joining and overlay of Stainless Steels of similar composition (Super Duplex). The analysis of the wire closely matches the base material to ensure the correct microstructure when welded. Used in the fabrication of plate and pipework in the Petro-chemical and Offshore industries. PREN >40.

#### BASE MATERIALS

Ferralium 255    Uranus 52N+  
Sumitomo DP3    VDM FALC 100  
Avesta 2507    Sandvik 2507

#### MECHANICAL PROPERTIES

~870 UTS n/mm	>690 YIELD 0.2%	>30 ELONG A5%	>130 (ISO-V) IMPACT (J)-50°C
------------------	--------------------	------------------	---------------------------------

#### METAL WELD COMPOSITION %

C	Si	Mn	Cr	Ni	Mo	S	P	Cu	W	Fe
0.01	0.4	0.7	25	9.2	3.5	0.002	0.02	0.7	0.6	BAL

#### PACKAGING

15kg Spools (MIG)  
5kg Tubes (TIG)

#### DIAMETERS

1.0, 1.2mm (MIG)  
1.6, 2.4, 3.2mm (TIG)

#### WELDING INSTRUCTIONS

Shielding gas MIG 5% or 20% CO<sub>2</sub> in Argon, 2% Argon-Ox or proprietary special gas. TIG 100% Argon. Do not allow the base material to overheat, maintain interpass temperature below 150°C.