



DAIKOSTRIP 2594

SAW - ESW

DUPLEX - SUPERDUPLEX

2507

PRODUCT DESCRIPTION

Nitrogen alloyed duplex strip electrode to deposit 25%Cr/10%Ni/4%Mo/N composition.

It is a nitrogen alloyed duplex chromium-nickel-molybdenum strip electrode to deposit a second and third layer corrosion resistant alloy of 25%Cr/10%Ni/4%Mo/N composition on carbon- and low alloyed steels. The high corrosion resistance of overlays using this strip electrode, makes it suitable for use in aggressive environments such as chlorinated seawater and acidic, chloride containing media up to temperatures of 280°C.

SPECIFICATIONS

AWS A5.9	EQ2594
EN ISO 14343-A	B 25 9 4 N L
DIN	-
Approvals	-
Shielding	DAIKOFLUX 930, 937AS

ASME IX QUALIFICATION

F-No (QW432)	6
A-No (QW442)	-

FERRITE

-

PREN

42

HARDNESS

-

Chemical composition (nominal)

Chemical composition (nominal) %

C	Si	Mn	P	S	Cr	Ni	Mo	N	Cu
0.020	0.3	0.4	0.020	0.015	25.0	9.5	4.0	0.25	0.1

Weld metal characteristics

Typical chemical composition of overlay in two layers without heat-treatment, and three layers including intermediate heat-treatment after buffer layer welding.

Chemical composition	DAIKOFLUX 930 wt%	C	Cr	Ni	Mo	N	FN, WRC	PRE
2nd layer		TO.03	24.0-25.5	9.0-10.0	3.7-4.2	0.20-0.25	50-60	41

DUPLEX - SUPERDUPLEX SS