



# Product Data Sheet

W 'Tungsten inert gas arc welding'

# OK Tigrod 2509

Prepared by Mats Linde	Qualified by Tero Tolonen	Approved by Jay A Coubrough	Reg no EN006546	Cancelling EN006059	Reg date 2014-09-18	Page 1 (2)
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## REASON FOR ISSUE

Removal of TUV approval

## GENERAL

Bare corrosion resisting "Super Duplex" rods for welding of austenitic-ferritic stainless alloys of 25% Cr, 7% Ni, 4%Mo, low C types.

OK Tigrod 2509 has high intergranular, pitting and stress corrosion resistance. The alloy is widely used in applications where corrosion resistance is of outmost importance. Pulp & paper industry, offshore and gas industry are areas of interest.

**Shielding Gas:** I1, I3 (EN ISO 14175)

**Alloy Type:** Austenitic-ferritic (25 % Cr - 10 % Ni - 4 % Mo - Low C)

## CLASSIFICATIONS Wire

EN ISO 14343-A W 25 9 4 N L  
SFA/AWS A5.9 ER2594

## CHEMICAL COMPOSITION

### Wire/Strip (%)

	Min	Max
C		0.02
Si	0.2	0.5
Mn	0.3	0.7
P		0.025
S		0.020
Cr	24.0	26.0
Ni	9.0	10.5
Mo	3.5	4.5
W		1.0
Cu		0.3
N	0.20	0.30

## MECHANICAL PROPERTIES OF WELD METAL

### All Weld Metal

Properties	As welded	
	Min	Typ
Rp0.2 (MPa)	550	660
Rm (MPa)	620	835
A4 (%)	18	37
Z (%)		60
at -20°C (J)		200
at -50°C (J)		180

Comments:  
Typical values tested according to AWS.



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## OTHER DATA

Welding should proceed with neither too low or too high heat input (general recommendation 0.2-1.5 kJ/mm).  
Interpass temperature 100 degr.

Typical Ferrite in weld metal: FN 30-50.

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