

LNT Zeron 100X

CLASSIFICATION

AWS A5.9	ER2594	A-Nr	8
ISO 14343-A	W 25 9 4 N L	F-Nr	6
		9606 FM	5

GENERAL DESCRIPTION

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

SHIELDING GASES (ACC. ISO 14175)

I1 Inert gas Ar (100%)

APPROVALS

TÜV

+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Ni	Mo	Cu	W	N
0.02	0.6	0.23	25	9.3	3.6	0.6	0.6	0.22

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	0.2% proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) -50°C
Typical values	I1	AW	655	934	42	100

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
		GX6 CrNiMo 24-8-2	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)	1.6	2.0	2.4	3.2	
5 kg PE-Tube	X	X	X	X	Note : Cut length = 1000 mm

LNT Zeron100X: rev. C-EN25-01/02/16