

Super duplex stainless and heat resistant steels

STARBLAZE PRIME 2595

Classification

AWS A5.4 : E2595-16

DIN EN ISO 3581-A : E 25 9 4 N LR 12

Description and applications

Rutile type non-synthetic 25-10-4-N electrode the welding of super-duplex stainless steels UNS S32750 (wrought) and UNS J93404 (cast) and similar compositions. Excellent resistant to pitting and crevice corrosion (PREN >40). Presence of Tungsten ensures highest resistance to hot cracking. Also used to weld standard duplex stainless steel such as UNS S31803 & S32205, Carbon and low alloy steels to duplex steels. Excellent weldability, spatter free arc, very smooth bead appearance. Weld metal has very high ferrite content in the range of 45-60FN. Satisfy pitting corrosion resistance at 25°C & 30°C as per ASTM G-48. Packed in vacuum pack system.

Base Materials

SAF 2507; UNS S32550, S32750, S32760 (Wrought); UNS J93404; J93370, J93380, CD4MCuN (Cast)
Material No. 1.4410, 1.4460, 1.4462, 1.4463

Typical weld metal Chemical Composition (%)

C	Mn	Si	Cr	Ni	Mo	P	S	N	Cu	W
0.03	1.20	0.80	25.40	9.50	4.00	0.015	0.010	0.24	1.00	0.60

All weld metal Mechanical properties (Typical)

Yield strength Rp (N/mm ²)	Tensile strength Rm (N/mm ²)	Elongation A5 (%)	Charpy Impact value ISO-V J RT	Ferrite No.	PREN
≥ 650	≥ 760	≥ 20	≥ 50	45-60	52

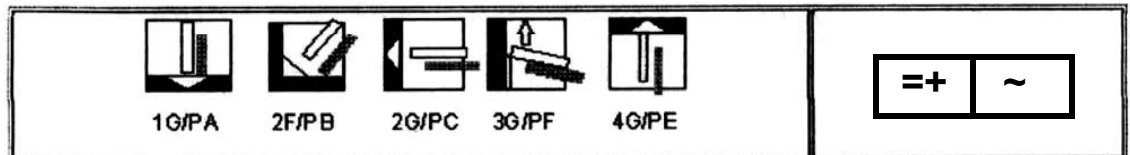
Amperes (A)

Dia (mm)	2.50mm	3.15mm	4.00mm
Amperage (A)	60 - 90	80 - 120	130- 160

Welding Instruction

Keep dry and avoid condensation.
Re-dry electrode at 300°C for 1 hour if necessary, 3 times max.

Welding positions



Stellaris Specialities India Ltd.

(Division: StarBlaze India)

GST No.: 06AAICS2482B1ZK / Legal Metrology No.: GOI/DL/2022/4850

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