

OK Autrod 2509

A continuous solid corrosion resisting "Super Duplex" wire for welding of austenitic-ferritic stainless alloys of 25% Cr, 10% Ni, 4% Mo, low C types. OK Autrod 2509 has a high intergranular corrosion resistance and pitting. The alloy is widely used in applications where corrosion resistance is of utmost importance. Pulp & paper industry, offshore and gas industry are areas of interest. OK Autrod 2509 can be used in combination with OK Flux 10.93 or OK Flux 10.94.

Classifications Wire Electrode	SFA/AWS A5.9 : ER2594 EN ISO 14343-A : S 25 9 4 N L
Approvals	CE EN 13479 VdTUV 12101

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic-ferritic (25% Cr - 10% Ni - 4% Mo - Low C)
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Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	N	PRE	FN WRC-92
0.01	0.4	0.4	9.4	25.2	3.9	0.24	42	50