



## OK Tigrod 2509

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 utmost importance. Pulp & paper industry, offshore and gas industry are areas of interest.

<b>Classifications</b>	EN ISO 14343 : W 25 9 4 NL
<b>Approvals</b>	UDT, DIN 8556 VdTUV 06593 (IT)

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

<b>Alloy Type</b>	Austenitic-ferritic (25 % Cr - 10 % Ni - 4 % Mo - Low C)
<b>Shielding Gas</b>	I1, I3, N2 (EN ISO 14175)

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	660 MPa (96 ksi)	835 MPa (121 ksi)	37 %

### Typical Charpy V-Notch Properties

Testing Temperature	Impact Value
-20 °C (-76 °F)	200 J (147.5 ft-lb)
-50 °C (-58 °F)	180 J (133 ft-lb)