



Product Data Sheet

S 'Submerged arc welding'

OK Autrod 2509

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REASON FOR ISSUE

OK Flux 10.94 added into the General description. AWS classification and CE-sign added.

GENERAL

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 outmost 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.

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

CLASSIFICATIONS Wire Electrode

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

APPROVALS

CE EN 13479
VdTÜV 12101

APPROVAL COMMENT

All others: See Flux-Wire combinations

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
Comments: PRE= %Cr + 3.3x%Mo + 16x%N min 40		