

❖ Product Description

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| I. An extra low carbon approximately 25%Cr type steel wire | III. High tensile strength |
| II. Has duplex microstructure consisting of an austenite-ferrite matrix structure | IV. Resistant to stress corrosion, cracking and improved resistance to pitting |
| | V. Radiographic weld quality |

❖ Range of Application

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| I. For welding duplex stainless steels | III. Can be applied for operating temperature upto 200°C |
| II. Surfacing of turbine blades and high pressure valves | |

❖ Classification

- AWS/SFA 5.9 ER2553

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	Cr	Cu	Mo	P	Ni	N
ER2553	Min	-	-	-	-	24.0	1.5	2.9	-	4.5	0.10
	Max	0.04	1.5	0.03	1.0	27.0	2.5	3.9	0.04	6.5	0.25

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charpy "v" Notch Impact @ -30°C
As Welded	760	-	15	-

❖ Wire Size & Welding Position

- Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60
- Weld Position- All position

❖ Current & Gas Flow

- DCEP; 15-22lit/min

❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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