

Avesta 2507/P100 rutile

Stick electrode

Classifications

high-alloyed

EN ISO 3581-A:

AWS A5.4:

E 25 9 4 N L R

E2594-16

Characteristics and field of use

Avesta 2507/P100 rutile is designed for welding super duplex steels such as 2507/1.4410. The weldability of duplex and super duplex steels is excellent, but the welding should be adapted to the base material, considering fluidity, joint design, heat input etc.

Base materials

For welding steels such as					
Outokumpu	EN	ASTM	BS	NF	SS
2507	1.4410	S32750	-	Z3 CND 25-06 Az	2328

Typical analysis of all-weld metal (Wt-%)

C	Si	Mn	Cr	Ni	Mo	N
0.03	0.5	1.3	25.2	9.5	3.6	0.23

Mechanical properties of all-weld metal

Heat Treatment	Yield strength 0.2%	Tensile strength	Elongation ($L_0=5d_0$)	Impact values in J CVN	
	MPa	MPa	%	+20°C:	-46°C:
untreated	700	900	26	80	45

Operating data

Polarity = + / ~

Dimensions (mm)**Amperage A**

2.5	50-70
3.25	80-100
4.0	100-140