

## MIG/MAG solid wires-TIG rods Stainless and Heat resistant steels

INERTFIL 25 10 4 is a G 25 9 4 N L type solid MAG welding wire, supplied precision layer wound, depositing a C-25Cr10Ni4Mo weld metal. Suitable for use with Ar+2%O<sub>2</sub> or Ar+0.5...5%CO<sub>2</sub> mixed shielding gases.

INERTFIL 25 10 4 is used for the welding of Super-Duplex stainless steels. Mainly used in Offshore applications, paper industry, oil industry and artificial manure production. This type is often used for root pass welding of 22%Cr standard duplex steels for critical applications, also for the welding of low carbon super martensitic 13%Cr steels.

INERTFIL 25 10 4 has a very good resistance to general corrosion, the weld metal has a high resistance to pitting with a PREN>40 value combined with a good resistance to crevice corrosion as well as stress corrosion cracking. The nickel over matches the parent material by 2-3% to provide an optimum balance of austenite and ferrite in the as welded condition.

### Classification

EN ISO	14343-A: G 25 9 4 N L
AWS	A5.9: ER 2594

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	N	Ferrite
0.010	0.6	0.5	≤ 0.020	≤ 0.020	25	9.5	4	0.25	35-70

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-40 °C
As Welded	≥ 550	≥ 800	≥ 25	≥ 80	≥ 32

Gas test: 98% Ar+2% O<sub>2</sub>

### Shielding Gas - EN ISO 14175 : M13

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+



### Packaging data

Packaging Type	BS300
Diam(mm) / weight(kg)	15
0.8	●
1.0	●
1.2	●