

INERTROD 25 10 4 is a W 25 9 4 N L type solid TIG welding rod depositing a C-25Cr 10Ni 4Mo weld metal. Suitable for use mainly with Ar shielding gas.

INERTROD 25 10 4 is used for the welding of super-duplex stainless steels. Mainly used in offshore applications, paper industry, oil industry and in the production of artificial manure. Used for root pass welding of 22%Cr standard duplex steels for critical applications, and for the welding of low carbon super martensitic 13%Cr steels.

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

Classification

EN ISO	14343-A: W 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
0.03	1	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: 100% Ar

Shielding Gas - EN ISO 14175 : I1

Materials

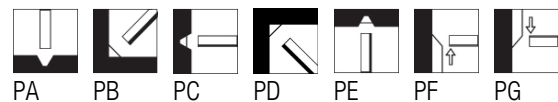
SAF 2507; Uranus 47N; UNS S32750; ASTM A182 F53

Storage

Keep dry and avoid condensation

Current condition and welding position

DC-



Packaging data

Diam. (mm)	Packaging Type	Weight (kg)	Code
1.6	TUB	5	●
2.0	TUB	5	●
2.4	TUB	5	●
3.2	TUB	5	●