

4460 Cu

CATEGORY SMAW Stick Electrodes

TYPE Rutile-Basic stainless steel electrode with extreme high corrosion resistance and mechanical properties.

APPLICATIONS Welding wrought, forged or cast super duplex stainless steels for service in the as-welded condition. Heterogeneous welding between super duplex stainless steels and dissimilar welds between other stainless and mild or low alloyed steels

PROPERTIES Higher corrosion resistance than standard Duplex steels with also higher mechanical properties due to the addition of Nitrogen.

CLASSIFICATION

AWS	A 5.4: E 2593-26
EN ISO	3581-A: E 25 9 3 N LR 32
DIN: W.Nr.	1.4501

SUITABLE FOR Welding wrought, forged or cast super duplex stainless steels for service in the as-welded Condition. Heterogeneous welding between super duplex stainless steels and dissimilar welds between other stainless and mild or low alloyed steels. Examples: UNS S32550 :UR 52 N, Ferralium 255, UNS S32520 :UR 52 N+, UNS S32750 :SAF 2507, UR 47 N+, UNS S32760 :ZERON 100, UNS 32760, UR 76 N, SM22Cr, SAF 2507, ASTM S32760 (ZERON 100), S32550 and S31260., It can also be used for welding duplex type 2205, 1.4460, 1.4462, 1.4463, 1.4515, 1.4517, 1.4507 URANUS 52N, SAF 25.07, GX 3 CrNiMoCuN 26-6-3, (1.4515), GX 3 CrNiMoCuN 26-6-3-3, (1.4517), 25% Cr Super Duplex steels SAF 25/07, S32750 1.4410 - 25Cr-7Ni-4Mo-0.28N SAF2507, NAS74N, S32760 1.4501 - 25Cr-7Ni-3.8Mo-0.7Cu-0.7W-0.25N, S32506 - SUS329J4L 25Cr-7Ni-3Mo-0.15N-0.2W NAS64 1.4507, S31803, S32205,

APPROVALS CE approved

WELDING POSITIONS:



WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Mo	Cu	N	Fe	W
<0.02	1.0-1.2	<0.80	24-26	8-10	2.5-3.5	0.5-0.8	0.15-0.18	Rem	0.5-0.7

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW	>550	>730	>23	50			

AW: as welded

WELDING PARAMETERS PACKING

Welding Parameters			Packing	
D (mm)	Length (mm)	Current (A) DC+/AC	kg / can	kg / 6pack
2.5	300	60-90	2.5	15
3.2	350	80-120	2.6	15.6
4.0	350	100-150	2.8	16.8

REDRYING TEMPERATURE 300°C/2hr

RECOVERY: 130%