

SACW Super Duplex

CATEGORY SAW Arc Submerged

TYPE High-alloyed tubular wire based on Super Duplex low carbon deposit for the Sub-Arc process

APPLICATIONS Welding forged or cast Super Duplex stainless steels for service in the as welded condition. For use where a high strength and good corrosion resistance is important in oil and gas production and processing system: pumps, valves, piping systems, risers etc.. SACW Super Duplex can also be used as an alternative for root welds to standard duplex to offer improved pitting resistance.

PROPERTIES Higher productivity, higher deposition rates and improved wetting properties compared to solid wires with excellent X ray soundness. Improved hot cracking resistance and mechanical properties. To be used with welding flux [FL 8111](#) or [FL 838](#)

CLASSIFICATION AWS A 5.9: (EC2553)
EN ISO 12073: S 25 9 3 Cu NL

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



WELD METAL ANALYSIS %

C	Mn	Si	Cr	Ni	Mo	Cu	N	P	S
0.020	0.70	0.60	25.5	8.9	3.8	1.60	0.25	0.015	0.010

REINES SCHWEISSGUT ERGEBNISSE

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V		
				-20°C	-40°C	-60°C
AW	550	620	18	47		

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool
1.6			Coil / Drum	25 / 330
2.4			Coil / Drum	25 / 330
3.2			Coil / Drum	25 / 330

REDRYING TEMPERATURE 150°C / 24hr