



# Cromasaw Duplex

SAW-Submerged arc welding  
Stainless Steel

Date: 2004-04-15  
Revision: 5

## Description:

Cromasaw Duplex is a submerged arc wire for use in combination with Cromaflex 300B, depositing a 23% Cr/9% Ni/3% Mo/0,15% N austenitic/ferritic duplex stainless steel weld metal with a ferrite content of about FN 45. Cromasaw Duplex is intended for welding similar composition duplex stainless steels which offer an excellent combination of high strength and very good resistance to chloride induced pitting and stress corrosion cracking. Pitting resistance equivalent, PRE=33.

	C	Si	Mn	P	S	Cr	Ni
Min			0,5			21,5	7,5
Typical	0,015	0,5	1,5			23,0	9,0
Max	0,03	0,9	2,5	0,03	0,02	23,5	9,5

	Mo	Cu	N
Min	2,5		0,10
Typical	3,2		0,15
Max	3,5	0,75	0,20

## Ferrite content:

FN 45

## Chemical composition, wt.%

	C	Si	Mn	Cr	Ni	Mo	N
Min							
Typical	0,015	0,7	1,2	22,5	9,0	3,2	0,13
Max							

## Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 450 MPa	600 MPa
Tensile Strength, Rm:	≥ 690 MPa	760 MPa
Elongation, A5	≥ 20%	25%
Impact energy, CV:	-40°C • >47 J	20°C • 120 J -20°C • 80 J -40°C • 60 J

## Product data

Product code	Diam.mm	Current A	Voltage V
9816-5024	2,4	300-500	26-30
9816-5032	3,2	300-500	28-30
9816-5040	4,0	300-500	28-32
		300-500	

## Classification:

EN 12072	S 22.9.3 LN
AWS A5.9	ER 2209
BS 2901	~22.8.3 S92
DIN 8556	X2 CrNiMo 22.9.3
Werkstoff no.	1.4462

## Approvals:

LR  
TÜV  
GL  
DNV

## Note

TR approved until 12 mm.