OK Autrod 2509

A continuous, solid, corrosion-resistant, “Super Duplex” wire for welding austenitic-ferritic, stainless alloys of the 25% Cr, 7% Ni, 4% Mo, low C types. OK Autrod 2509 has high intergranular-corrosion, pitting and stress-corrosion resistance. The alloy is widely used in applications in which corrosion resistance is of the utmost importance. The pulp and paper industry, offshore and gas industry are areas of interest.

Classifications Wire Electrode:	SFA/AWS A5.9:ER2594, EN ISO 14343-A:G 25 9 4 N L
Approvals:	CE EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As welded	659 MPa (95.5 ksi)	832 MPa (121 ksi)	30 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As welded	20 °C (68 °F)	159 J (117 ft-lb)
As welded	-40 °C (-40 °F)	129 J (95 ft-lb)

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	N
0.01	0.4	0.4	9.4	25.2	3.9	0.24

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm (.040 in.)	80-190 A	16-24 V	2.9-8.4 m/min (114-331 in./min)	1.1-3.1 kg/h (2.4-6.8 lb/h)
1.2 mm (3/64 in.)	180-280 A	20-28 V	4.9-8.5 m/min (193-335 in./min)	2.6-4.5 kg/h (5.7-9.9 lb/h)

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