

INERTROD 25 10 4

TIG Rods Stainless and Heat resistant steels

Inertrod 25 10 4 is a TIG rod for welding super duplex stainless steels (UNS 32520, UNS 32520 UNS 32750 UNS 32760). The welding of pressure vessels is a typical application. The heat input should be in the range within 0,4 – 1,4 kJ/mm.

Classification	
EN	12072: 25 9 4 L

Approvals	Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.03	1	0.50	≤ 0.020	≤ 0.020	25	9.50	4	-	-	0.22	35-70

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -30°C	Hardness
As Welded	≥ 550	≥ 620	≥ 18	≥ 30	-

Gas test: Acc. To EN 439: I1(Arcal1)

Shielding Gas: Acc. To EN 439: I1(Arcal1)









Materials

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

Storage

Keep dry and avoid condensation

Current condition and welding position

DC-							
							
PA	PB	PC	PG	PF	PE	PG2	PF2

Packaging data: Tube 5 kg

Diameters (L: 1000 mm)	2,4					
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Further forms of delivery on request.