

MT- Superduplex

~1.4410

Standard designation

EN ISO 14343-A	G/W 25 9 4 NL
Material No.	~1.4410
AWS/ASME SFA-5.9	~ER 25 9 4

Main fields of application

1.4410	X 2 CrNiMoN 25 7 4	1.4469	X 2 CrNiMoN 26 7 4
1.4467	X 2 CrMnNiMoN 26 5 4	1.4501	X 2 CrNiMoCuWN 25 7 4
1.4468	GX 2 CrNiMoN 25 6 3	1.4515	GX 3 CrNiMoCuN 26 6 3
1.4507	X 2 CrNiMoCuN 25 6 3	1.4508	GX2CrNiMoCuWN25-8-4

Mechanical properties of all – weld – metal

(typical values)

Gas shield Thermal treatment Test temperature		[°C]	M 12 untreated +20°
0,2%-yield strength	R _{p0,2}	MPa	670
Tensile strength	R _m	MPa	850
Elongation	A ₅	[%]	25
Impact strength	A _V	(J)	120

Average chemical composition of all-weld-metal (%)

C	Si	Mn	Cr	Mo	Ni	N	Cu
0,02	0,6	2,5	24,0-27,0	2,5-4,5	8,0-10,5	0,20-0,30	1,5

Gas types applicable TIG Gas types applicable MIG

I1
M 12, M 13

TIG rod diameters, unit weights

Diameter [mm]	Length [mm]	Kg per box [kg]
1,60	1000	10,0
2,00	1000	10,0
2,40	1000	10,0
3,20	1000	10,0

MIG welding wire:

Diameter 0,8mm 1,0mm 1,2mm 1,6mm

Welding positions MIG acc.to EN ISO 6947 Welding positions TIG acc.to EN ISO 6947

PA, PB, PF, PC, PG
PA, PB, PC, PF

Current/Polarity WIG

= -

Current/Polarity TIG

= +