LNT Zeron 100X

GENERAL DESCRIPTION
Solid rod for welding Zeron 100® and other super duplex stainless steel grades
High resistance to pitting and crevice corrosion in seawater

SHIELDING GASES (ACC. ISO 14175)
Π  Inert gas Ar (100%)

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

<table>
<thead>
<tr>
<th>C</th>
<th>Mn</th>
<th>Si</th>
<th>Cr</th>
<th>Ni</th>
<th>Mo</th>
<th>Cu</th>
<th>W</th>
<th>N</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.02</td>
<td>0.6</td>
<td>0.23</td>
<td>25</td>
<td>9.3</td>
<td>3.6</td>
<td>0.6</td>
<td>0.6</td>
<td>0.22</td>
</tr>
</tbody>
</table>

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

<table>
<thead>
<tr>
<th>Shielding gas</th>
<th>Condition</th>
<th>0.2% proof strength (N/mm²)</th>
<th>Tensile strength (N/mm²)</th>
<th>Elongation (%)</th>
<th>Impact ISO-V(J) -50°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Π</td>
<td>AW</td>
<td>655</td>
<td>934</td>
<td>42</td>
<td>100</td>
</tr>
</tbody>
</table>

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades | EN 10088-1/-2 | Mat. Nr | UNS |
-------------|---------------|---------|-----|
Regular and super duplex stainless steels
X2CrNiMoN25-7-4  | 1.4410         |         |     |
X4CrNiMoN27-5-2  | 1.4460         |         |     |
X2CrNiMoN22-5-3  | 1.4462         | 2205    | S31803|
GX6 CrNiMo 24-8-2| 1.4463         |         |     |
CD-4MCu          | S32550         |         |     |
Zeron 100        | S32760         |         |     |

Super duplex stainless Steel grades: chemical composition approximately:
24-27% Cr, 6-9% Ni, 3-4% Mo, 0.10-0.25% N alloyed also with Cu and/or W

PACKAGING AND AVAILABLE SIZES

<table>
<thead>
<tr>
<th>Diameter (mm)</th>
<th>1.6</th>
<th>2.0</th>
<th>2.4</th>
<th>3.2</th>
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<tbody>
<tr>
<td>5 kg PE-Tube</td>
<td>X</td>
<td>X</td>
<td>X</td>
<td>X</td>
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</tbody>
</table>

Note: Cut length = 1000 mm