

TECHNICAL DATA

Standards

DIN Material Nr. 1.4501

EN ISO 14343-A :	G 2594 N L
AWS A5.9 :	ER2594

General Properties / Field of Applications

DSI M Connect 3Plus is a Super Duplex Laser Welding Wire of nitrogen containing ferrite-austenitic CrNiMo-steels for welding of stainless ferrite-austenitic super duplex steels for operating temperatures up to 250°C. Very good resistance to pitting and stress corrosion cracking. High resistant to phosphoric acid. Protect abrasive erosion for casting sand patterns. Applicable for offshore, chemical and petrochemical.

Mechanical Properties

Yield strength $R_{p0.2}$	[MPa] / [N/mm ²]	620
Tensile strength R_m	[MPa] / [N/mm ²]	770
Elongation A ($L_0 = 5d_0$)	[%]	24
Impact Work KV	[J]	120 at +20°C

Chemical Composition (Standard Values in %)

C	Si	Mn	Cr	Ni	Mo	Cu	W	N
0.02	0.4	0.6	25.1	9.1	3.9	0.1	<0.1	0.25

Compatible Materials (Selection)

25% Cr super duplex steels / 1.4507 X2CrNiMoCuN25-6-3 / 1.4515 / 1.4517 / 1.4573
1.4410 X2CrNiMoN25-7-4 / 1.4539 / ASTM A 182 Gr. F59 / A 240 Gr. 255

Packaging and available Sizes*

Spool : MA125 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2
Rod : 500 / 1000 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2

* Other dimensions available on request

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