

Classifications

EN ISO 17633-B:2008	: TS2553-FC0	JIS Z 3323	: TS2553-FC0
AWS A5.22-15	: E2553T0-G		

Description

- K-325T is formulated for MAG welding of 25%Cr-9%Ni-3%MoCu duplex stainless steels and the typical application is chemical plant and shipbuilding as well as nuclear plant industries (UNS S32520, UNS S32550, S32750, S32900, JIS 329J4L)
- Wire is a titania type of flux cored wire for flat and horizontal position welding, and provides low spatter and fume generation and high efficiency in flat position
- It has better pitting corrosion resistance and stress corrosion cracking resistance compared to the E2209TX-XXX welding consumables type.

Welding positions**Polarity & shielding gas**

- CO₂: 100% CO₂ (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	Mo	PREN	FN
CO ₂	0.03	0.50	0.80	25.60	9.00	3.6	40.5	55

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20°C	-40°C	
AWS A5.22		min. 690	min. 20			
EN ISO 17633-B	min. 350	min. 690	min. 15			
Example	750	860	25	42	27	CO ₂

Notes on usage and welding condition

- Refer to page 303 for more information on usage
- When heat input is excessive, base metal will be bended or distorted due to the bad heat conductivity. Therefore, perform welding with selecting proper heat input

Package

Dia. (mm)	0.9	1.2	1.6
Spool (kg)	5, 12.5, 15		