

TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

RNY2595

● Applicable Specification

JIS Z 3221 ES329J4L-16
AWS A5.4 E2595-16

● Identification Color

End Face: Purple
Side Face:—

● Applications and Characteristics

TASETO RNY2595 is used for welding of super duplex stainless steel such as UNS S32760. It exhibits excellent corrosion resistibility in industrial water containing chlorine ion in small concentration. Resistibility to stress corrosion cracking, pitting corrosion and sea water corrosion is excellent too. Hot cracking resistibility of the all weld metal is good.

RNY2595 is a lime-titania type electrode of good usability in positional welding.

● Notes on Usage

* Dry the electrode at 150°C to 200°C for 60 minutes before use.

* Post weld heat treatment adversely affects embrittlement.

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu	N	W
Typical	0.033	0.58	0.74	0.021	0.002	9.46	25.13	3.98	0.53	0.24	0.58

● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)
Typical	737	923	22.0

● Other Properties of All Weld Metal

* 6% Ferric Chloride Test : No pitting at 35°C × 24h

● Sizes Available, Recommended Currents (AC or DCEP)

Size (mm)	Length (mm)	Welding Current (A)	
		Flat	Vertical, Overhead
2.6	300	50~90	45~80
3.2	350	80~120	65~110
4.0	350	110~150	85~135
5.0	350	150~200	—