

QuNi25

(W.-Nr. 2.4655)

is used for joining and repairing similar alloys. Welding of CrNiMoCu - austenitic alloy steels which are found in the chemical industry, in high quality vessels and apparatus constructions which come into contact with sulfur - phosphor acids.

Recommended for:

1.4500, 1.4529, 1.4539, 1.4563, 2.4619, 2.4858

Rework

material-typical treatment

Material analysis in %

C	Si	Mn	Cr	Ni	Mo	Cu	Fe
< 0,02	<0,3	2,5	25,5	41,0	5,0	2,0	Rest

(test certificates upon request.)

Standard/Mechanical Values

Ø	N / mm ²	elongation AL100	Items on stock rods	Items on stock spools
0,2	-	-	-	-
0,3	-	-	-	-
0,4	-	-	-	-
0,5	-	-	-	-
0,6	-	-	-	-
0,7	-	-	-	-
0,8	-	-	-	-

Hardness after welding

Ø	HRC	base material
1. layer		
2. layer		
3. layer		

(results on request)

Following standard:

Laser welding wires

rods: 333 mm / 1.000 mm

spool: K80 / K125 / K250 / SH253 / MA125

(The reported values were determined by the manufacturer and / or by a neutral Laboratory determined. For the accuracy we can not guarantee)