

TIGO[®] 2553

PREMIUM WELDING WIRES

Flux cored wire for welding of 25% Cr, 9% Ni & 3% Mo duplex stainless steel alloys.

GRADE	AWS A5.22/A5.22M E2553T1-1
PROPERTIES	<ul style="list-style-type: none">• All position wire with exhibiting excellent smooth beads.• Provides excellent arc stability, low spatter and high deposition.• Self-peeling slag and easy post weld finishing.• Weld exhibits high tensile & yield strength along with improved resistance to corrosion, pitting and stress corrosion cracking.

TYPICAL ANALYSIS OF ALL-WELD METAL %

C	Si	Mn	P	Cr	Ni	Mo	N
0.025	0.70	1.05	0.015	24.00-27.00	8.05-10.05	2.90-3.90	0.1-0.25

TYPICAL ANALYSIS OF ALL-WELD METAL %

Tensile Strength MPa	Yield Strength MPa	Elongation %
790	---	17.5

WELDING PARAMETERS

Polarity	Shielding Gas	Amps A	Voltage V
DC+	75%Ar/ CO ₂ 25% or 100%Co ₂	150-240	24-32

PACKING

Wire Dia in MM.	Packing per spool
1.20	12.5 Kgs



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