

# CSF-2553P

Super Duplex stainless steel

AWS A5.22 E2553T1-1/4  
JIS Z3323 TS2553-FB1

## Applications

CSF-2553P is suitable for Welding of 25%Cr-9%Ni-3%Mo-N Stainless steel.

## Characteristics

- (1) CSF-2553P is flux cored wire and designed for Fillet & H-F(All-position) welding with CO<sub>2</sub> gas or 75%Ar+25%CO<sub>2</sub> gas Shielding.
- (2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.
- (3) Is containing Ferrite of a reasonable quantity and crack-resistance, intergranular corrosion resistance, mechanical properties of weld metal is superior.
- (4) Shield gas is 100%CO<sub>2</sub> or Ar+CO<sub>2</sub> gas.

## Notes on usage

- (1) The optimum flow of CO<sub>2</sub> for Shielding is 20~25ℓ/min.
- (2) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- (3) Keep the distance between tip & base metal at 15~25mm.

## Typical chemical composition of weld metal (%)

(Shielding Gas : 100%CO<sub>2</sub>)

C	Mn	Si	Cr	Ni	Mo	Cu	N	FN
0.03	0.98	0.59	24.3	8.4	3.2	1.8	0.15	50

## Typical mechanical properties of weld metal

(Shielding Gas : 100%CO<sub>2</sub>)

YP N/mm <sup>2</sup> (MPa)	TS N/mm <sup>2</sup> (MPa)	EL %	IV (J)
			-40℃
698	860	21.2	31.2

## Size & recommended current range (DC +)

Dia. mm (in)	Current(A)	Voltage(V)	Welding Speed(cm /min)
1.2(0.045)	150~300	24~33	20~60
1.6(0.062)	200~400	24~33	20~60