

**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**

- CO<sub>2</sub>: 100% CO<sub>2</sub> (15~25ℓ/min)
- DCEP (DC+)

**Typical chemical composition of all-weld metal (%)**

Shielding gas	C	Si	Mn	Cr	Ni	Mo	PREN	FN
CO <sub>2</sub>	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 <sub>2</sub>

**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		