



CEWELD AA 2594

TYPE	Rutile fluxcored wire for Super Duplex (Zeron 100)										
ANWENDUNGEN	Duplex stainless steels in chemical industry such as offshore, tubing, vessel, boilers etc										
EIGENSCHAFTEN	CEWELD® AA 2594 is a flux cored wire designed for welding 25Cr type duplex stainless steels especially for Super Duplex grade, PRE (Pitting Resistance Equivalent) is over 45.										
KLASSIFIKATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.22: ~E2594T1-1</td> </tr> <tr> <td>EN ISO</td> <td>17633-A: T 25 9 4 N L P M21 1</td> </tr> <tr> <td>W.Nr.</td> <td>1.4501</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>	AWS	A 5.22: ~E2594T1-1	EN ISO	17633-A: T 25 9 4 N L P M21 1	W.Nr.	1.4501	F-nr	6	FM	5
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EN ISO	17633-A: T 25 9 4 N L P M21 1										
W.Nr.	1.4501										
F-nr	6										
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GEEIGNET FÜR	<p>1.4507, 1.4410, 1.4468, 1.4515, 1.4517, 1.4501, 1.4467, 1.4569, 1.4508 X2 CrNiMoCuN 25-6-3, X2 CrNiMoN 25-7-4, GX2 CrNiMoN 25-6-3, GX2 CrNiMoCuN 26-6-3, GX2 CrNiMoCuN 25-6-3-3, X2 CrNiMoCuWN 25-7-4, X2CrMnNiMoN26-5-4, X 2 CrNiMoN 26 7 4, GX2CrNiMoCuWN25-8-4 UNS S32520, S32550, S32750, S39274, S39277, S39553, S32760, J93380 Ferralium 255, SAF 2507, ZERON 100, UR 76 N, SM22Cr, SAF 2507, Alloy 2507, Alloy 2594</p>										

ZULASSUNGEN CE

SCHWEISSPOSITIONEN



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo	N
0.025	0.6	1.4	0.025	0.015	26	9	3	0.15

MECHANISCHE GÜTEWERTE

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
				-20°C	-40°C	-80°C	
As Welded	720	920	27	50	40	30	HRc

RÜCKTROCKNUNG 140°C / 24 hr

GAS ACC. EN ISO 14175 M21



CEWELD AA 2594

AA 2594 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663414793
D-200	5	8720663414809