



# CEWELD SA 2594

**TYPE** SAW wire for welding the so called Super Duplex types of stainless steels.

**ANWENDUNGEN** Welding austenitic-ferritic, stainless alloys of the 25% Cr, 7% Ni, 4% Mo, low C types. Welding wrought, forged or cast super duplex stainless steels for service in the as-welded Condition. Heterogeneous welding between super duplex stainless steels and dissimilar welds between other stainless and mild or low alloyed steels. The alloy is widely used in applications in which corrosion resistance is of the utmost importance. The pulp & paper industry, offshore and gas industry are areas of interest.

**EIGENSCHAFTEN** SA 2594 has high intergranular-corrosion, pitting and stress-corrosion resistance with exceptional mechanical strength properties when welded with our high basic agglomerated flux FL 838.

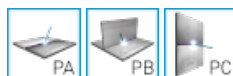
**KLASSIFIKATION**

AWS	A 5.9: ER2594
EN ISO	14343-A: S 25 9 4 N L
W.Nr.	1.4410
F-nr	6
FM	5

**GEEIGNET FÜR** 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

**ZULASSUNGEN** CE

**SCHWEISSPOSITIONEN**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	P	S	Cr	Ni	Mo	N	W
0.025	0.6	1.2	0.02	0.015	25	9	3.7	0.2	0.4

**MECHANISCHE GÜTEWERTE**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT	-40°C	
As Welded	620	820	20	70	55	HRc

**RÜCKTROCKNUNG** Not required

**GAS ACC. EN ISO 14175**



# CEWELD SA 2594

SA 2594 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663414670

SA 2594 3,2MM

Packaging	KG/unit	EanCode
K-415	25	8720663414687