



CEWELD AA 2594

TYPE	Rutile fluxcored wire for Super Duplex (Zeron 100)																				
APPLICATIONS	Duplex stainless steels in chemical industry such as offshore, tubing, vessel, boilers etc																				
PROPERTIES	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 40. Ar-CO2 mixed gas or 100%CO2 is recommended as shielding gas for excellent weldability.																				
CLASSIFICATION	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																			
SUITABLE FOR	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 Ferratum 255, SAF 2507, ZERON 100, UR 76 N, SM22Cr, SAF 2507, Alloy 2507, Alloy 2594																				
APPROVALS	CE																				
WELDING POSITIONS																					
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>N</th> </tr> </thead> <tbody> <tr> <td>0.025</td> <td>0.6</td> <td>1.4</td> <td>0.025</td> <td>0.015</td> <td>26</td> <td>9</td> <td>3</td> <td>0.15</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Mo	N	0.025	0.6	1.4	0.025	0.015	26	9	3	0.15		
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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														
REDRYING	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