










CEWELD 2594 Tig (Super Duplex)

TYPE	Tig filler metal for welding Super Duplex types of stainless steels.									
APPLICATIONS	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.									
PROPERTIES	2594 offers high intergranular-corrosion, pitting and stress-corrosion resistance with exceptional mechanical strength properties.									
CLASSIFICATION	AWS	A 5.9: ER2594								
	EN ISO	14343-A: W 25 9 4 N L								
	F-nr	6								
	FM	5								
	W.Nr.	1.4410								
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 Ferrallium 255, SAF 2507, ZERON 100, UR 76 N, SM22Cr, SAF 2507, Alloy 2507, Alloy 2594									
APPROVALS	CE									
WELDING POSITIONS	<div>PAPBPCPDPEPFPG</div>									
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo	N	W
	0.02	0.6	1.2	0.01	0.01	25	9	3.5	0.2	0.4
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V					
					-20°C		-40°C			
	As Welded /	620	780	26	60		50			
REDRYING TEMPERATURE	Not required									
GAS ACCORDING EN 14175	I1									