

CEWELD SACW 2594 Super Duplex



TYPE High-alloyed cored wire based on Super Duplex low carbon deposit for the Sub-Arc process. (Typ

2594, 1.4410)

APPLICATIONS Welding forget or cast Super Duplex stainless steels for service in the as welded condition. For use

where a high strength and good corrosion resistance is important in oil and gas production and processing system: pumps, valves, piping systems, risers etc.. SACW Super Duplex can also be used as an alternative for root welds to standard duplex to offer improved pitting resistance. 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.

PROPERTIES Higher productivity, higher deposition rates and improved wetting properties compared to solid

wires with excellent \boldsymbol{X} ray soundness. Improved hot cracking resistance and mechanical properties.

To be used with welding flux FL 8111 or FL 838

CLASSIFICATION AWS A 5.9: ER2594

EN ISO 14343-A: S 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

Ferralium 255, SAF 2507, ZERON 100, UR 76 N, SM22Cr, SAF 2507, Alloy 2507, Alloy 2594, Super

Duplex

APPROVALS No Approvals Found

WELDING POSITIONS



ALL WELD MECHANICAL

PROPERTIES

Heat	R _{P0,2}	Rm	A5	Impact Energy (J) ISO-V	
Treatment	MPa	MPa	(%)	RT	-40°C
As Welded /	620	810	20	70	55

REDRYING TEMPERATURE 140°C / 24 hr

GAS ACCORDING EN 14175