



# 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
AWS	A 5.22: ~E2594T1-4
EN ISO	17633-A: T 25 9 4 N L P M21 1
F-nr	6
FM	5
W.Nr.	1.4501

**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

**APPROVALS** CE

**WELDING POSITIONS**



**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

**ALL WELD MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		
				-20°C	-40°C	-80°C
As Welded /	720	920	27	50	40	30

**REDRYING TEMPERATURE** 140°C / 24 hr

**GAS ACCORDING EN 14175** M21



# CEWELD AA 2594

AA 2594 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663414793
D-200	5	8720663414809