



CEWELD AA 2594

TYPE	Rutile fluxcored wire for Super Duplex (Zeron 100)								
ANWENDUNGEN	Duplex stainless steels in chemical industry such as offshore, tubing, vessel, boilers etc								
EIGENSCHAFTEN	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 45.								
KLASSIFIKATION	AWS	A 5.22: ~E2594T1-1, A 5.22: ~E2594T1-4							
	EN ISO	17633-A: T 25 9 4 N L P M21 1							
	W.Nr.	1.4501							
	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, Super Duplex								
ZULASSUNGEN	CE								
SCHWEISSPOSITIONEN									
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Mn	P	S	Cr	Ni	Mo	N
	0.025	0.6	1.4	0.025	0.015	26	9	3	0.15
MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness	
	As Welded	720	920	27	-20°C	-40°C	-80°C	HRc	
					50	40	30		
RÜCKTROCKNUNG	140°C / 24 hr								
GAS ACC. EN ISO 14175	M21								



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AA 2594 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663414793
D-200	5	8720663414809