



CEWELD SACW 2594 Super Duplex

TYPE	High-alloyed tubular wire based on Super Duplex low carbon deposit for the Sub-Arc process	
ANWENDUNGEN	Welding forged 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.	
EIGENSCHAFTEN	Higher productivity, higher deposition rates and improved wetting properties compared to solid wires with excellent X ray soundness. Improved hot cracking resistance and mechanical properties. To be used with welding flux FL 8111 or FL 838	
KLASSIFIKATION	AWS EN ISO W.Nr. F-nr FM	A 5.9: ER2594 14343-A: S 25 9 4 N L 1.4410 6 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

SCHWEISSPOSITIONEN



MECHANISCHE GÜTEWERTE

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT	-40°C	
As Welded	620	810	20	70	55	HRc

RÜCKTROCKNUNG 140°C / 24 hr

GAS ACC. EN ISO 14175