



CEWELD 2594 Super Duplex

TYPE 2594 Super Duplex stainless steel Mig/Mag GMAW welding wire for Zeron 100, Uranus 76, SAF 2507 and similar alloys

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 CEWELD 2594 has high intergranular-corrosion, pitting and stress-corrosion resistance with exceptional mechanical strength properties.

CLASSIFICATION

AWS	A 5.9: ER2594
EN ISO	14343-A: G 25 9 4 N L
W.Nr.	1.4410
F-nr	6
FM	5

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 2594, Super Duplex

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Cr	Ni	Mo	N	W
	0.02	0.6	1.2	25	9	3.5	0.2	0.4

MECHANICAL PROPERTIES	Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
					-20°C	-40°C	
	As Welded	700	900	27	65	55	HRC

REDRYING Not required

GAS ACC. EN ISO 14175 M13, M12



CEWELD 2594 Super Duplex

2594 SUPER DUPLEX 0,8MM	Packaging	KG/unit	EanCode
	BS-300	15	8720663414694
2594 SUPER DUPLEX 1,0MM	Packaging	KG/unit	EanCode
	BS-300	15	8720663414700
2594 SUPER DUPLEX 1,2MM	Packaging	KG/unit	EanCode
	BS-300	15	8720663414717