



CEWELD SA 2594

TYPE SAW wire for welding the so called Super Duplex types of stainless steels.

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 SA 2594 has high intergranular-corrosion, pitting and stress-corrosion resistance with exceptional mechanical strength properties when welded with our high basic agglomerated flux FL 838.

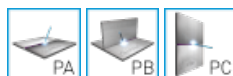
CLASSIFICATION

| | |
|--------|-----------------------|
| AWS | A 5.9: ER2594 |
| EN ISO | 14343-A: S 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 2507, Alloy 2594

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

| C | Si | Mn | P | S | Cr | Ni | Mo | N | W |
|-------|-----|-----|------|-------|----|----|-----|-----|-----|
| 0.025 | 0.6 | 1.2 | 0.02 | 0.015 | 25 | 9 | 3.7 | 0.2 | 0.4 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{P0.2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|-------|----------|
| | | | | RT | -40°C | |
| As Welded | 620 | 820 | 20 | 70 | 55 | HRc |

REDRYING Not required

GAS ACC. EN ISO 14175



CEWELD SA 2594

SA 2594 2,4MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| K-415 | 25 | 8720663414670 |

SA 2594 3,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| K-415 | 25 | 8720663414687 |