



# CEWELD SA 2594

|                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                         |                      |                    |                         |       |    |          |     |     |
|------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------------------|-------------------------|-------|----|----------|-----|-----|
| TYPE                                           | SAW wire for welding the so called Super Duplex types of stainless steels.                                                                                                                                                                                                                                                                                                                                                                                                                                             |                         |                      |                    |                         |       |    |          |     |     |
| ANWENDUNGEN                                    | 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. |                         |                      |                    |                         |       |    |          |     |     |
| EIGENSCHAFTEN                                  | 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.                                                                                                                                                                                                                                                                                                                            |                         |                      |                    |                         |       |    |          |     |     |
| KLASSIFIKATION                                 | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | A 5.9: ER2594           |                      |                    |                         |       |    |          |     |     |
|                                                | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 14343-A: S 25 9 4 N L   |                      |                    |                         |       |    |          |     |     |
|                                                | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 1.4410                  |                      |                    |                         |       |    |          |     |     |
|                                                | 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<br>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<br>UNS S32520, S32550, S32750, S39274, S39277, S39553, S32760, J93380<br>Ferrallium 255, SAF 2507, ZERON 100, UR 76 N, SM22Cr, SAF 2507, Alloy 2507, Alloy 2594, Super Duplex                                                                     |                         |                      |                    |                         |       |    |          |     |     |
| ZULASSUNGEN                                    | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                         |                      |                    |                         |       |    |          |     |     |
| SCHWEISSPOSITIONEN                             | <div>PAPBPC</div>                                                                                                                                                                                                                                             |                         |                      |                    |                         |       |    |          |     |     |
| TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%) | 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 |
| MECHANISCHE GÜTEWERTE                          | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |       |    | Hardness |     |     |
|                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                         |                      |                    | RT                      | -40°C |    |          |     |     |
|                                                | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 620                     | 820                  | 20                 | 70                      | 55    |    | HRc      |     |     |
| RÜCKTROCKNUNG                                  | 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 |