



# CEWELD AA 2594

<b>TYPE</b>	Rutile fluxcored wire for Super Duplex (Zeron 100)																				
<b>APPLICATIONS</b>	Duplex stainless steels in chemical industry such as offshore, tubing, vessel, boilers etc																				
<b>PROPERTIES</b>	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 40. Ar-CO2 mixed gas or 100%CO2 is recommended as shielding gas for excellent weldability.																				
<b>CLASSIFICATION</b>	AWS	A 5.22: ~E2594T1-1																			
	EN ISO	17633-A: T 25 9 4 N L P M21 1																			
	W.Nr.	1.4501																			
	F-nr	6																			
	FM	5																			
<b>SUITABLE FOR</b>	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 Ferratum 255, SAF 2507, ZERON 100, UR 76 N, SM22Cr, SAF 2507, Alloy 2507, Alloy 2594																				
<b>APPROVALS</b>	CE																				
<b>WELDING POSITIONS</b>																					
<b>TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)</b>	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>N</th> </tr> </thead> <tbody> <tr> <td>0.025</td> <td>0.6</td> <td>1.4</td> <td>0.025</td> <td>0.015</td> <td>26</td> <td>9</td> <td>3</td> <td>0.15</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Mo	N	0.025	0.6	1.4	0.025	0.015	26	9	3	0.15		
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		-20°C	-40°C	-80°C																	
As Welded	720	920	27	50	40	30	HRC														
<b>REDRYING</b>	140°C / 24 hr																				
<b>GAS ACC. EN ISO 14175</b>	M21																				



# CEWELD AA 2594

AA 2594 1,2MM

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