



CEWELD AA 2594M

TYPE	Metal cored wire designed for welding 25Cr type duplex stainless																				
APPLICATIONS	Duplex stainless steels in chemical industry such as offshore, tubing, vessel, boilers etc																				
PROPERTIES	AA 2594M is a metal cored wire designed for welding 25Cr type duplex stainless steels especially for Super Duplex grade. Excellent productivity, improved weldability, better wetting properties compared to solid wires. Excellent weld metal quality and X-ray soundness																				
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.22: ~E2594T1-1</td> </tr> <tr> <td>EN ISO</td> <td>17633-A: T 25 9 4 Cu N L M M12 1</td> </tr> <tr> <td>W.Nr.</td> <td>1.4410</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>	AWS	A 5.22: ~E2594T1-1	EN ISO	17633-A: T 25 9 4 Cu N L M M12 1	W.Nr.	1.4410	F-nr	6	FM	5										
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SUITABLE FOR	<p>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</p>																				
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WELDING POSITIONS																					
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>N</th> <th>Cu</th> <th>S</th> </tr> </thead> <tbody> <tr> <td>0.025</td> <td>0.6</td> <td>1.4</td> <td>0.025</td> <td>25.5</td> <td>9</td> <td>3.5</td> <td>0.25</td> <td>0.6</td> <td>0.015</td> </tr> </tbody> </table>	C	Si	Mn	P	Cr	Ni	Mo	N	Cu	S	0.025	0.6	1.4	0.025	25.5	9	3.5	0.25	0.6	0.015
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		-46°C																			
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REDRYING	Not required																				
GAS ACC. EN ISO 14175	M21																				



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AA 2594M 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663414786