



# CEWELD AA 2594M

**TYPE** Metal cored wire designed for welding 25Cr type duplex stainless

**TOEPASSINGEN** Duplex stainless steels in chemical industry such as offshore, tubing, vessel, boilers etc

**EIGENSCHAPPEN** 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

**CLASSIFICATIE**

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

**GESCHIKT VOOR** 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

**GOEDKEURINGEN** CE

**LASPOSITIES**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

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

**MECHANISCHE WAARDEN**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				-46°C		
As Welded	580	680	20	40		HRc

**HERDROGEN** Not required

**GAS ACC. EN ISO 14175** M21



# CEWELD AA 2594M

AA 2594M 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663414786