



CEWELD 2594 Tig (Super Duplex)

TYPE Tig filler metal for welding Super Duplex types of stainless steels.

APPLICATIONS CEWELD® 2594 Super Duplex Tig was specially developed for welding super duplex ferritic-austenitic steels (25% Cr, 9% Ni, 4% Mo). It is characterized by high tensile strength and toughness as well as excellent resistance to stress corrosion cracking, pitting, and intergranular corrosion. The operating temperature range is between -50 °C and 250 °C. The alloy is often used in applications where corrosion resistance is of paramount importance. The pulp and paper industry, as well as the offshore and gas industries, are areas of interest.

PROPERTIES CEWELD® 2594 Super Duplex Tig exhibits high resistance to intergranular corrosion, pitting, and stress corrosion cracking, and has exceptional mechanical strength properties. Particularly in H2S-containing environments. Suitable for operating temperatures from -40°C to +220°C.

CLASSIFICATION

AWS	A 5.9: ER2594
EN ISO	14343-A: W 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, Super Duplex

APPROVALS CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo	N	W
0.02	0.6	1.2	0.01	0.01	25	9	3.5	0.2	0.4

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-20°C	-40°C	
As Welded	620	780	26	60	50	HRC

REDRYING Not required

GAS ACC. EN ISO 14175 11