



# CEWELD AA 2594

TYPE	Rutile fluxcored wire for Super Duplex (Zeron 100)																			
APPLICATIONS	<p>CEWELD® AA 2594 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.</p> <p>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.</p>																			
PROPERTIES	<p>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.</p>																			
CLASSIFICATION	<p>AWS            A 5.22: ~E2594T1-1, A 5.22: ~E2594T1-4          EN ISO        17633-A: T 25 9 4 N L P M21 1          W.Nr.         ~1.4501          F-nr           6          FM             5</p>																			
SUITABLE FOR	<p><b>ISO 15608: 10.2-10.3 Austenitic &gt; 24 % Cr ≤ 4% Ni, DUPLEX 2594, 25%Cr 9%Ni 4%Mo</b>          1.4410, 1.4467, 1.4468, 1.4501, 1.4507, 1.4508, 1.4515, 1.4517, 1.4569          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, J93404          Ferralium 255, SAF 2507, ZERON 100, UR 76 N, SM22Cr, SAF 2507, Alloy 2507, Alloy 2594, Super Duplex, Uranus® 47N</p>																			
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WELDING POSITIONS																				
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <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													
REDRYING	140°C / 24 hr																			
GAS ACC. EN ISO 14175	M21																			



# CEWELD AA 2594

AA 2594 1,2MM

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