



# CEWELD SACW 2594 Super Duplex

TYPE	High-alloyed cored wire based on Super Duplex low carbon deposit for the Sub-Arc process. (Typ 2594, 1.4410)										
APPLICATIONS	CEWELD® SACW 2594 Super Duplex 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® SACW 2594 Super Duplex 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. He has a higher productivity, higher deposition rates and improved wetting properties compared to solid wires with excellent X ray soundness. Improved hot cracking resistance and mechanical properties. To be used with welding flux FL 8111 or FL 838										
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.9: ER2594</td> </tr> <tr> <td>EN ISO</td> <td>14343-A: S 25 9 4 N L</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 5.9: ER2594	EN ISO	14343-A: S 25 9 4 N L	W.Nr.	1.4410	F-nr	6	FM	5
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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>										

APPROVALS

WELDING POSITIONS



MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT	-40°C	
As Welded	620	810	20	70	55	HRc

REDRYING 140°C / 24 hr

GAS ACC. EN ISO 14175