



CEWELD SACW 2594 Super Duplex

certilas® THE FILLER METAL SPECIALIST

TYPE High-alloyed cored wire based on Super Duplex low carbon deposit for the Sub-Arc process. (Typ 2594, 1.4410)

APPLICATIONS Welding forged or cast Super Duplex stainless steels for service in the as welded condition. For use where a high strength and good corrosion resistance is important in oil and gas production and processing system: pumps, valves, piping systems, risers etc.. SACW Super Duplex can also be used as an alternative for root welds to standard duplex to offer improved pitting resistance. Welding wrought, forged or cast super duplex stainless steels for service in the as-welded Condition. Heterogeneous welding between super duplex stainless steels and dissimilar welds between other stainless and mild or low alloyed steels.

PROPERTIES 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

| | |
|--------|-----------------------|
| AWS | A 5.9: ER2594 |
| EN ISO | 14343-A: S 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

WELDING POSITIONS



| MECHANICAL PROPERTIES | Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A5 (%) | 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