



# CEWELD 2594 Super Duplex

**TYPE** 2594 Super Duplex stainless steel Mig/Mag GMAW welding wire for Zeron 100, Uranus 76, SAF 2507 and similar alloys

**APPLICATIONS** CEWELD® 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® 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.

**CLASSIFICATION**

AWS	A 5.9: ER2594
EN ISO	14343-A: G 25 9 4 N L
W.Nr.	1.4410
F-nr	6
FM	5

**SUITABLE FOR** ISO 15608: 10.2-10.3 Austenitic > 24 % Cr ≤ 4% Ni, DUPLEX 2594, 25%Cr 9%Ni 4%Mo  
 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

**APPROVALS** CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

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

**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
				-20°C	-40°C	
As Welded	700	900	27	65	55	HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M13, M12



# CEWELD 2594 Super Duplex

2594 SUPER DUPLEX 0,8MM	Packaging	KG/unit	EanCode
	BS-300	15	8720663414694
2594 SUPER DUPLEX 1,0MM	Packaging	KG/unit	EanCode
	BS-300	15	8720663414700
2594 SUPER DUPLEX 1,2MM	Packaging	KG/unit	EanCode
	BS-300	15	8720663414717