



CEWELD AA 2594

TYPE Rutile fluxcored wire for Super Duplex (Zeron 100)

ANWENDUNGEN Duplex stainless steels in chemical industry such as offshore, tubing, vessel, boilers etc

EIGENSCHAFTEN 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 45.

KLASSIFIKATION

AWS	A 5.22: ~E2594T1-1
EN ISO	17633-A: T 25 9 4 N L P M21 1
W.Nr.	1.4501
F-nr	6
FM	5

GEEIGNET FÜR 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

ZULASSUNGEN CE

SCHWEISSPOSITIONEN



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo	N
0.025	0.6	1.4	0.025	0.015	26	9	3	0.15

MECHANISCHE GÜTEWERTE

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
				-20°C	-40°C	-80°C	
As Welded	720	920	27	50	40	30	HRc

RÜCKTROCKNUNG 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