CEWELD 2594 Tig (Super Duplex)

certilas® THE FILLER METAL SPECIALIST

TYPE

Tig filler metal for welding Super Duplex types of stainless steels.

APPLICATIONS

Welding austenitic-ferritic, stainless alloys of the 25% Cr, 7% Ni, 4% Mo, low C types. 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. The alloy is widely used in applications in which corrosion resistance is of the utmost importance. The pulp & paper industry, offshore and gas industry are areas of interest.

PROPERTIES

2594 offers high intergranular-corrosion, pitting and stress-corrosion resistance with exceptional mechanical strength properties.

CLASSIFICATION

AWS	A 5.9: ER2594
EN ISO	14343-A: W 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

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo	N	W
0.02	0.6	1.2	0.01	0.01	25	9	3.5	0.2	0.4

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-20°C	-40°C	
As Welded	620	780	26	60	50	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

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