



# CEWELD SACW 2594 Super Duplex

**TYPE** High-alloyed tubular wire based on Super Duplex low carbon deposit for the Sub-Arc process

**TOEPASSINGEN** 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.

**EIGENSCHAPPEN** 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

**CLASSIFICATIE**

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

**GESCHIKT VOOR** 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

**GOEDKEURINGEN**

**LASPOSITIES**



(%)

**MECHANISCHE WAARDEN**

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

**HERDROGEN** 140°C / 24 hr

**GAS ACC. EN ISO 14175**