CEWELD AA 2594

certilas® THE FILLER METAL SPECIALIST

TYPE

Rutile fluxcored wire for Super Duplex (Zeron 100)

APPLICATIONS

CEWELD® AA 2594 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® 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 40. Ar-CO2 mixed gas or 100%CO2 is recommended as shielding gas for excellent weldability.

CLASSIFICATION

AWS	A 5.22: ~E2594T1-1, A 5.22: ~E2594T1-4
EN ISO	17633-A: T 25 9 4 N L P M21 1
W.Nr.	~1.4501
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 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

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V			Hardness
				-20°C	-40°C	-80°C	
As Welded	720	920	27	50	40	30	HRc

REDRYING

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