

CATEGORY FCAW Flux-Cored

TYPE Metal cored wire designed for welding 25Cr type duplex stainless

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

PROPERTIES AA 2594M is a metal cored wire designed for welding 25Cr type duplex stainless steels especially for Super Duplex grade. Excellent productivity, improved weldability, better wetting properties compared to solid wires. Excellent weld metal quality and X-ray soundness

CLASSIFICATION

AWS	A 5.22: ~E2594T1-1
EN ISO	17633-A: T 25 9 4 Cu N L M M12 1
F-nr	6
FM	5
W.Nr.	1.4410
W.Nr.	1.4501

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
 Ferratum 255, SAF 2507, ZERON 100, UR 76 N, SM22Cr, SAF 2507, Alloy 2507, Alloy 2594

APPROVALS CE

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	Cr	Ni	Mo	N	Cu	S
0.025	0.6	1.4	0.025	25.5	9	3.5	0.25	0.6	0.015

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2}	R _m	A ₅	Impact Energy (J) ISO-V
	MPa	MPa	(%)	-46°C
As Welded /	580	680	20	40

WELDING PARAMETERS / PACKING

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 M21