



CEWELD AA 2594M

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								
	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, Super Duplex									
APPROVALS	CE									
WELDING POSITIONS	PAPBPCPF									
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
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V				Hardness	
					-46°C					
	As Welded	580	680	20	40				HRc	
REDRYING	Not required									
GAS ACC. EN ISO 14175	M21									



CEWELD AA 2594M

AA 2594M 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663414786