



CEWELD AA 2594

TYPE	Fil fourré rutile E2594T1-1 pour Super Duplex (Zeron 100)																			
APPLICATIONS	Aciers inoxydables duplex dans l'industrie chimique : offshore, tubes, cuves, chaudières, etc.																			
PROPRIÉTÉS	CEWELD® AA 2594 est un fil fourré conçu pour le soudage des aciers inoxydables duplex de type 25Cr, en particulier pour la nuance Super Duplex, PRE (Pitting Resistance Equivalent) supérieure à 45.																			
CLASSIFICATION	AWS EN ISO W.Nr. F-nr FM A 5.22: ~E2594T1-1, A 5.22: ~E2594T1-4 17633-A: T 25 9 4 N L P M21 1 ~1.4501 6 5																			
CONVIENT POUR	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																			
AGRÉMENTS	CE																			
POSITIONS DE SOUDAGE	 PA  PB  PC  PD  PE  PF																			
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	<table><tr><th>C</th><th>Si</th><th>Mn</th><th>P</th><th>S</th><th>Cr</th><th>Ni</th><th>Mo</th><th>N</th></tr><tr><td>0.025</td><td>0.6</td><td>1.4</td><td>0.025</td><td>0.015</td><td>26</td><td>9</td><td>3</td><td>0.15</td></tr></table>	C	Si	Mn	P	S	Cr	Ni	Mo	N	0.025	0.6	1.4	0.025	0.015	26	9	3	0.15	
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PROPRIÉTÉS MÉCANIQUES	<table><tr><th rowspan="2">Heat Treatment</th><th rowspan="2">R_{P0,2} (MPa)</th><th rowspan="2">R_m (MPa)</th><th rowspan="2">A₅ (%)</th><th colspan="3">Impact Energy (J) ISO-V</th><th rowspan="2">Hardness</th></tr><tr><th>-20°C</th><th>-40°C</th><th>-80°C</th></tr><tr><td>As Welded</td><td>720</td><td>920</td><td>27</td><td>50</td><td>40</td><td>30</td><td>HRc</td></tr></table>	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness	-20°C	-40°C	-80°C	As Welded	720	920	27	50	40	30	HRc
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		-20°C	-40°C	-80°C																
As Welded	720	920	27	50	40	30	HRc													
ETUVAGE	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