



CEWELD AA 2594

TYPE	Rutile fluxcored wire for Super Duplex (Zeron 100)									
ANWENDUNGEN	Duplex stainless steels in chemical industry such as offshore, tubing, vessel, boilers etc									
EIGENSCHAFTEN	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 45.									
KLASSIFIKATION	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								
GEEIGNET FÜR	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									
ZULASSUNGEN	CE									
SCHWEISSPOSITIONEN	PAPBPCPDPEPF									
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Mn	P	S	Cr	Ni	Mo	N	
	0.025	0.6	1.4	0.025	0.015	26	9	3	0.15	
MECHANISCHE GÜTEWERTE	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness		
	As Welded	720	920	27	-20°C	-40°C	-80°C	HRc		
					50	40	30			
RÜCKTROCKNUNG	140°C / 24 hr									
GAS ACC. EN ISO 14175	M21									



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AA 2594 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663414793
D-200	5	8720663414809