



# 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	<p>AWS A 5.22: ~E2594T1-1, A 5.22: ~E2594T1-4</p> <p>EN ISO 17633-A: T 25 9 4 N L P M21 1</p> <p>W.Nr. ~1.4501</p> <p>F-nr 6</p> <p>FM 5</p>																			
CONVIENT POUR	<p><b>ISO 15608: 10.2-10.3 Austenitic &gt; 24 % Cr ≤ 4% Ni, DUPLEX 2594, 25%Cr 9%Ni 4%Mo</b></p> <p>1.4410, 1.4467, 1.4468, 1.4501, 1.4507, 1.4508, 1.4515, 1.4517, 1.4569</p> <p>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</p> <p>UNS S32520, S32550, S32750, S39274, S39277, S39553, S32760, J93380, J93404</p> <p>Ferralium 255, SAF 2507, ZERON 100, UR 76 N, SM22Cr, SAF 2507, Alloy 2507, Alloy 2594, Super Duplex, Uranus® 47N</p>																			
AGRÉMENTS	CE																			
POSITIONS DE SOUDAGE																				
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	<table border="1"> <thead> <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> </thead> <tbody> <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> </tbody> </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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		-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