



# CEWELD AA 2594

TYPE	Rutiel gevulde draad voor Super Duplex (Zeron 100)																			
TOEPASSINGEN	Duplex roestvast staal in de chemische industrie, zoals offshore, buizen, vaten, boilers enz...																			
EIGENSCHAPPEN	CEWELD® AA 2594 is een gevulde draad voor het lassen van duplex roestvast staal van het type 25Cr, speciaal voor Super Duplex, PRE (Pitting Resistance Equivalent) is meer dan 45.																			
CLASSIFICATIE	<table border="0"> <tr> <td>AWS</td> <td>A 5.22: ~E2594T1-1, A 5.22: ~E2594T1-4</td> </tr> <tr> <td>EN ISO</td> <td>17633-A: T 25 9 4 N L P M21 1</td> </tr> <tr> <td>W.Nr.</td> <td>~1.4501</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>	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									
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GESCHIKT VOOR	<p><b>ISO 15608: 10.2-10.3 Austenitic &gt; 24 % Cr ≤ 4% Ni, DUPLEX 2594, 25%Cr 9%Ni 4%Mo</b>            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</p>																			
GOEDKEURINGEN	CE																			
LASPOSITIES																				
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<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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MECHANISCHE WAARDEN	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>P0,2</sub> (MPa)</th> <th rowspan="2">R<sub>m</sub> (MPa)</th> <th rowspan="2">A<sub>5</sub> (%)</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> </thead> <tbody> <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> </tbody> </table>	Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	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													
HERDROGEN	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