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Inox 2594R

Rutile Coated Electrode
For Super-Duplex Stainless Steels

FSH WELDING GROUP
INNOVATIVE WELDING CONSUMABLES
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Classification

AWS A5.4 : E2594-16
ISO 3581-A : E 25 9 4 N L R 32
EN1600 : E 25 9 4 N L R 32

Description & Applications

Rutile type coated electrode with an austenitic-ferritic microstructure (duplex ~ 40% ferrite). The weld metal can be applied for operation temperatures up to 250°C and is resistant in chloride containing medias against pitting as well as crevice and stress corrosion.
For but welding and cladding of steels with an austenitic - ferritic structure, of the same or similar composition, which are used for pumps, vessels, piping systems etc. attacked by chloride containing solutions. But also for impellers and other components which require high strength combined with corrosion attack. Pitting index: > 40.

Base materials:

UNS	Alloy	EN 10088	Material N°	CLI
S31803		X2CrNiMoN22-5-3	1.4462	URANUS 45
S32550	52N	G-X2CrNiMoCuN26 6 3	1.4517	URANUS 52N
	52N+	X2CrNiMoCuN25-6-3	1.4507	URANUS 52N+
S32750	2507	X2CrNiMoN25-7-4	1.4410	
S32760	100	X2CrNiMoCuWN25-7-4	1.4501	URANUS 70N
S32900	329	X3CrNiMoN27-5-2	1.4460	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	N	Fe
0.03	0.9	0.9	25.0	9.5	4.0	0.6	0.21	Rem.

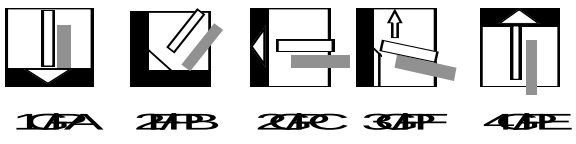
All Weld Metal Mechanical Properties

$R_{p0,2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
720	860	22	+20°C 60

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350
Current	(A)	70-85	90-110	120-145

Redrying 2-3h at 250-300°C. Guide electrodes with a slight declination and weld with a short arc. Interpass temperature: <150 °C.



= +	~ 70V

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