

❖ Product Description

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| I. An extra low carbon 25/9/4 type super duplex SS TIG rod | IV. Improved high resistant to stress corrosion, cracking and improved resistance to pitting |
| II. Austenitic-ferritic duplex microstructure | V. Radiographic weld quality |
| III. High tensile and yield strength | |

❖ Range of Application

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| I. For welding super duplex stainless steels UNS S 32750, S 32760, SFA 2507, Zeron 100 and Casting alloys e.g. ASTM A890 Gr.5A | III. Process equipment in offshore oil and gas industries, petrochemical plant |
| II. Pipe work system, flow lines, risers, manifolds, pumps & valves | IV. Can be used on duplex 2205 grade |

❖ Classification

- AWS/SFA 5.9 ER2594

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	Cr	Cu	Mo	P	Ni	N	W
ER2594	Min	-	-	-	-	24.0	-	2.5	-	8.0	0.20	-
	Max	0.03	2.5	0.02	1.0	27.0	1.5	4.5	0.03	10.5	0.30	1.0

❖ Mechanical Properties of all weld metal

Condition	UTS, Mpa (Min)	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ -30°C
As Welded	760	-	15	-

❖ Wire Size & Welding Position

- Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60
- Weld Position- All position

❖ Current & Gas Flow

- DCEP; 15-22lit/min

❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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