



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	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																			
CONVIENT POUR	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																				
AGRÉMENTS	CE																				
POSITIONS DE SOUDAGE	     																				
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	<table><tr><td>C</td><td>Si</td><td>Mn</td><td>P</td><td>S</td><td>Cr</td><td>Ni</td><td>Mo</td><td>N</td></tr><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></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		
C	Si	Mn	P	S	Cr	Ni	Mo	N													
0.025	0.6	1.4	0.025	0.015	26	9	3	0.15													
PROPRIÉTÉS MÉCANIQUES	<table><tr><th rowspan="2">Heat Treatment</th><th rowspan="2">R_{P0,2} (MPa)</th><th rowspan="2">R_m (MPa)</th><th rowspan="2">A₅ (%)</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><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></table>	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness	-20°C	-40°C	-80°C	As Welded	720	920	27	50	40	30	HRc	
Heat Treatment	R _{P0,2} (MPa)					R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness										
		-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