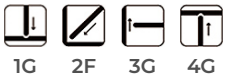
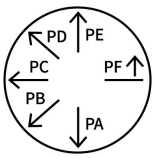
SW-2594 Cored

Classification

AWS AWS A5.22/ ASME SFA-5.22 E2594T1-1/-4
EN 17633-A T 25 9 4 N L P M21/C1 2

Welding Positions





Features

- Designed for welding with CO2 & Ar+CO2 mixed shielding gas.
- This wire is designed for Super Duplex stainless steels.
- Arc stability is excellent, so spatter loss is low and slag covering is uniform with good removability

Polarity

DC +

Application Areas

- Super Duplex stainless steel welding(NAS 329J4L, UNSS32750)

Shielding Gas

100% CO2
Ar+20~25% CO2

Typical Chemical Composition of All-Weld Metal (wt%)

Shielding Gas	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	N2
100% CO2	0.02	0.4	0.7	0.018	0.002	0.02	9.2	25.5	3.7	0.24
Ar + 20% CO2	0.03	0.5	0.7	0.012	0.001	0.02	9.1	25.7	3.7	0.23

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
100% CO2	688 (100)	896 (130)	24	-20(0) -50(-60)	27(20) 20(15)
Ar+20~25% CO2	680 (90)	891(129)	26	-20(0) -50(-60)	37(27) 30(22)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2(0.045)	160~220	Spool 5kg (11lbs), 12.5kg(28lbs), 15kg (33lbs)