Supercored 2594

Classification

AWS AWS A5.22/ ASME SFA-5.22 E2594T0-1

Features

- Designed for Super Duplex Stainless steels has a slow freezing slag which enables Flat and horizontal position welding

- Arc stability is excellent, so spatter loss is Low and slag covering is uniform with good removability

Polarity

DC+

Application Areas

- Welding of Super Duplex Stainless steels like UNS S32750, S32760

Shielding Gas

100% CO2

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

Shielding Gas	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	N
100% CO2	0.02	0.6	0.6	0.014	0.003	0.03	9.0	24.8	3.9	0.21

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	767 (111)	882 (128)	25	-20 (-4) -50 (-58)	30 (22.1) 24 (17.7)

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)