



# Super-Duplex 2594 FCW

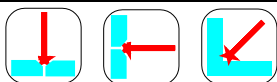
AWS A 5.22: E2594 T0-4

EN ISO 17633-A: T 25 9 4 Cu N L R M21 3

## DESCRIPTION

Routile special flux cored super-duplex wire for welding super- duplex grades. Heterogeneous welding between superduplex stainless steels and other stainless and mild or low alloyed steels.

### WELDING POSITIONS



### CURRENT

= DC +

### GAS

M20/M21

## BASE MATERIAL

1.4507, 1.4507, 1.4410, 1.4468, 1.4515, 1.4517, 1.4501

## MECHANICAL PROPERTIES

<i>R<sub>m</sub></i> (Mpa)	<i>R<sub>p 0,2</sub></i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>
850	670	25	+20°C: 45

## WELD METAL COMPOSITION(%)

C	Mn	Si	Cr	Ni	Mo	Cu	N
0,03	1,4	0,6	25,0	9,0	3,8	1,0	0,26

## PACKAGING

Dimension (mm)	1,2	1,6		
Spool/drum (kg)	5/15/330	15/15/330		
Volt (V)	24-35	24-35		
Ampere (A)	130-250	150-300		
Stick out (mm)	12-25	12-25		
Gas flow (l/min)	10-20	10-20		

## EQUIVALENT FILLER METALS

MMA	Meltolit Super-Duplex 2594 E
Mig	Meltolit Super-Duplex 2594 XM
Tig	Meltolit Super-Duplex 2594 XT