

### CLASSIFICATIONS

EN ISO 14343-A : W 25 9 4 N L

AWS A5.9 : ER2594

### DESCRIPTION

- WI SG 2594 is a super duplex welding wire.
- Used for the welding Austenitic-Ferritic stainless alloys of %25 Cr, %9 Ni, %3.5 Mo and low C types
- It has high resistance to intergranular corrosion and pitting
- WI SG 2594 2594 is intended for welding super duplex alloys such as 2507, ASTM S32760, S32550 and A31260
- As the shielding gas, Argon (Ar) is used

### CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.02 | Si: 0.35 | Mn: 0.70 | Cr: 25.0 | Ni: 9.00 | Mo: 3.80

### MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation ( $L_0=5d_0$ ) (%)	Impact Strength (ISO-V/+20°C)
550	760	min. 18	min. 47 J

### BASE MATERIALS

- (1.4501)X2CrNiMoCuWN25-7-4, (1.4515)GX3CrNiMoCuN26-6-3,  
(1.4517)GX3CrNiMoCuN25-6-3-3, UNS S 32750, S 32760 ZERON 100, SAF 25/07, FALC100

### WELDING POSITIONS



### CURRENT CONDITION

TIG D.C. (-)

### OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
1011100078	1.60 x 1000	1/16 x 39"	5	Plastic Box
1011100079	2.00 x 1000	5/64 x 39"	5	Plastic Box
1011100080	2.40 x 1000	3/32 x 39"	5	Plastic Box