

STRONG FCAW E2594

CLASSIFICATION: AWS SFA 5.22 E2594T1-1/4

STAINLESS STEEL FLUX CORED ARC WELDING WIRE



CHARACTERISTICS

STRONG FCAW E2594 is an all-position, rutile based gas shielded super-duplex stainless steel flux-cored wire designed for welding of 25Cr/9Ni/4Mo/Cu alloy duplex stainless steels. This wire has a smooth spray like arc transfer at higher amperages and a globular transfer at lower amperages. This wire has a smooth-running arc that deposits a very high tensile strength, with very good resistance to stress, corrosion, cracking and pitting. Other key features include Stable arc, low spatter, easy slag removal and radiographic quality welds.

APPLICATIONS

STRONG FCAW E2594 is designed for typical application in Paper & Pulp, chemical plant/shipbuilding as well as seawater & nuclear plant industries and base metals such as S32900, 2507 (UNS S32750), S32550, S31260(DP-3), S32750, J93380 or other proprietary super duplex alloys.

TYPICAL WELD METAL CHEMISTRY (%)

C	Mn	Si	N	Cu	Cr	Ni	Mo
0.04 MAX	0.50- 2.00	1.00 MAX	0.20- 0.30	1.50 MAX	24.0- 27.0	8.50- 10.5	2.50- 4.50

ALL WELD MECHANICAL PROPERTIES

Required as per AWS 5.22	Y.S. MPa	U.T.S. MPa	ELONGATION %
Typical Results As Welded	660	825	24

PACKAGING SPECIFICATIONS - FCAW

DIA SIZE 1.20MM / 1.60MM

SPOOL WEIGHT 12.5KGS