

# ROYAL ER 2594 (ER 2594)

AWS / SFA 5.9 ER 2594 EN ISO 14343 A G/W 25 9 4 N L

## Applications

Suitable for welding of super duplex stainless steel UNS S31750 and 32760 (Wrought) and UNS J 93380 , J 93404 (Cast). It can be used for welding of UNS S 32550, J 93370, J 93372 when not subject to sulfurous or sulfuric acid in service. Also suitable for welding of Carbon and low alloy steel to Duplex Stainless Steel.

## Characteristics on Usage

The nominal composition of this wire rod is 25.5%Cr, 9.2% Ni, 3.5 % Mo , 0.25% N. Weld deposit having PREN is atleast 40 thereby allowing the weld metal called 'Super Duplex Stainless Steel'.

## Packing

Each Packets content 5 kg of Wire Rods having length 500 mm.,1000mm.

MIG TIG WIRES

## Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %
0.03 Max	2.50 Max	1.0 Max	0.020 Max	0.030 Max	24.0-27.0
Ni %	Mo%	N%	Cu%	W%	
8.0-10.5	2.5-4.5	0.20-0.30	1.50 Max	1.0 Max	

## Mechanical Properties Of Weld Metal

U.T.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
760 Min	15.0 Min %