

❖ Product Description

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| <ul style="list-style-type: none"> I. Gas shielded, extra low carbon, duplex rutile type FCW wire II. Low fumes, very less spatter. III. Superduplex stainless steel has higher Cr and Mo content, provides greater corrosion resistance | <ul style="list-style-type: none"> IV. Contains two phase microstructure of weld deposit contains Austenite and Ferrite, which gives improves strength V. Uniform and fine ripples VI. Radiographic weld quality |
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❖ Range of Application

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| <ul style="list-style-type: none"> I. Extremely good for welding of Welding of Superduplex stainless steels UNS S 32750 & S 32760 (wrought) & UNS J93380 & J93404Caste II. Welding of low alloys steels to duplex steels such as E2205 & E2209 | <ul style="list-style-type: none"> III. In offshore applications IV. In piping, oil industry, pressure vessels, valves and pumps |
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❖ Classification

- AWS/SFA 5.22 E2594 T1

❖ % Chemical Composition

Type of Wire		C	Mn	Si	S	P	Cr	Ni	N	Cu
E2594 T1	Min	-	0.50	-	-	-	24.0	8	0.20	-
	Max	0.04	2.50	1.0	0.03	0.04	27.0	10.5	0.30	1.5

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ -30°C
PWHT	760	-	15	-

❖ Wire Size & Welding Position

- Diameter in mm- 1.2, 1.6
- Weld Position- All position

❖ Current & Gas Flow

- DCEP; 18-25lit/min

❖ Packaging

- Standard packaging in 15kg Spool form

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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