

❖ Product Description

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|---|---|
| I. A weld metal of composition 2-3%Nickel | V. Increased tensile strength and resistance to stress corrosion cracking |
| II. Provides optimum ferrite ratio in finished weld | VI. Good resistance to pitting |
| III. Spatter free, smooth arc | |
| IV. Excellent and uniform weld beads | |

❖ Range of Application

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| I. For welding wrought super duplex alloys such as 2507 and Zeron 100 | II. Also for welding super-duplex casting alloys ASTM A890 |
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❖ Classification

- AWS/SFA 5.9 E2594

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	P	Cu	Cr	Mo	Ni	N	W
E2594	Min	-	-	-	-	-	-	24.0	2.5	8.0	0.20	-
	Max	0.03	2.5	0.02	1.0	0.03	0.75	27.0	4.5	10.5	0.30	1.0

❖ Wire Size & Welding Position

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|---|-------------------------------|
| • Diameter in mm- 1.60, 2.00, 2.40, 3.20, 4.00, 5.00. | • Weld Position- All position |
|---|-------------------------------|

❖ Packaging

- 25kg coil with or without support

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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