DW-2594 PREMIARC™

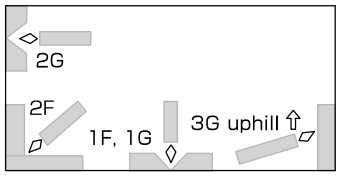
Flux cored wire

Features: ▪ Suitable for super duplex stainless steel (S32750, S32760, etc.)

Classification: AWS A5.22 E2594T1-1/4

Shielding gas: CO_2 or Ar-CO_2
Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool
1.2	12.5kg
Volume mm	295W, 110H, 295L

Composition (all-weld metal mass%)

	Typical (Ar-CO_2)	Guaranty [a]
C	0.03	0.04
Si	0.5	1.0
Mn	1.2	0.5~2.5
P	0.02	0.04
S	<0.01	0.03
Ni	9.5	8.0~10.5
Cr	25.5	24.0~27.0
Mo	3.8	2.5~4.5
Cu	<0.1	1.5
W	<0.1	1.0
N	0.22	0.20~0.30

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G	3G uphill
1.2	130~250	150~220	130~180

All-weld mechanical properties

	Typical (Ar-CO_2)	Guaranty
0.2%YS (MPa)	714	-
TS (MPa)	896	759min.
El on 4d (%)	28	15min.
IV -40℃ (J)	38	-

Approvals

ABS	MG
LR	S32750S (CHEM), Dup/CMnS (CHEM)
DNV	MG (AWS A5.22 E2594T1-1)
BV	UP
NK	MG
CWB	E2594T1-1, E2594T1-4

Note: CO_2, except in CWB