NC-2594 PREMIARC™

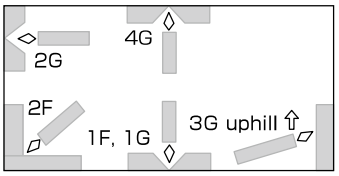
Stick electrode

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

Classification: AWS A5.4 E2594-16

Redrying Conditions: 250~350℃x1~2h
Identification color: -
Polarity: AC, DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	20	300W, 95H, 330L
3.2	350	5	20	35	175W, 135H, 380L
4.0	350	5	20	53	175W, 130H, 380L
5.0	350	5	20	79	175W, 130H, 380L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.03	0.04
Si	0.55	1.00
Mn	0.7	0.5~2.0
P	0.02	0.04
S	<0.01	0.03
Ni	9.3	8.0~10.5
Cr	25.4	24.0~27.0
Mo	3.9	3.5~4.5
N	0.24	0.20~0.30
Cu	0.05	0.75

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	75~95	70~90
3.2	85~120	80~115
4.0	110~160	90~140
5.0	150~200	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	750	-
TS (MPa)	935	759min.
El on 4d (%)	28	15min.
IV -50℃ (J)	40	-

Approvals

DNV	MG