

# S-2594.16

Type : Rutile

## Conformances

AWS A5.4/ ASME SFA5.4 E2594-16

EN ISO 3581-A-E 25 9 4 N L

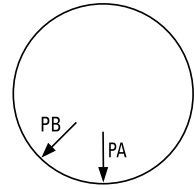
## Applications

- Welding of super duplex stainless steel (UNS S32750, S32760)

## Features

- Service temperature up to 250°C
- High resistance to Pitting corrosion and embrittlement
- PREN 41
- Easy to remove slag
- Good bead appearance

## Welding Position



## Current

AC or DC ±

## Redrying Conditions

350°C (662°F) X 1hr

## Diameter / Packaging

Diameter	Length	P.V.C	
		packet	carton
mm (in)	mm (in)	2.5kg(5.5lbs)	10kg(22lbs)
2.6 (3/32)	350 (14)	✓	
3.2 (1/8)	350 (14)	✓	
4.0 (5/32)	400 (16)	✓	
5.0 (3/16)	400 (16)	✓	
6.0 (15/64)	450 (18)	✓	

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	Cr	Ni	Mo	N
0.019	0.58	0.53	25.17	8.9	3.9	0.22

## Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.lbs)
830 (120,400)	28.0	-20(-4) -50(-58)	35 (25) 30 (22)

## Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	300 (12)	300 (12)	350 (14)	350 (14)	350 (14)
F & HF	25-55	50-85	70-115	95-145	135-180
V-up, OH	20-50	45-80	65-110	85-135	-

SWAW

SAW

GMWAW

GTAW

FCAW

Non-FERROUS

APPENDIX