

ESSEN[®] FC 2594

AC/ DC +

Grade: AWS A5.22 E2594T1-1/4

Flux cored wire for welding of 25% Cr super duplex stainless steel (S32750, S32760) in service temperature upto 280°C. Heterogenous welding between duplex stainless steel and other stainless and low alloy steels. It can also be used as overmatching consumable for 21-23%Cr duplex stainless steels.

PROPERTIES

- Provides excellent arc stability, low spatter and high deposition.
- Titania type flux cored containing give smooth and uniform beads.
- Self-peeling slag and easy post weld finishing.

TYPICAL ANALYSIS OF ALL -WELD METAL %

C	Si	Mn	P	Cr	Ni	Mo
0.03	0.60	0.9	0.015	25.00	9.70	4.00

TYPICAL ANALYSIS OF ALL -WELD METAL %

Tensile Strength MPa	Yield Strength MPa	Elongation %	Impact test J -20°C
900	690	25	30 (min)

WELDING PARAMETERS :

Polarity	Shielding Gas	Amps A	Voltage V
DC+	75%Ar/ CO ₂ 25%	150-240	24-32

PACKING

Wire Dia in MM.	Packaging per spool
1.20	12.5 Kgs



ESSEN
WELDING ALLOYS PVT. LTD.



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PREMIUM WELDING ALLOYS

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