



SWASTIK-WELD

JINIK MARKETING

Swastik Weld Make Welding Wire GMAW/GTAW (MIG & TIG) for Duplex & Super Duplex Steel

II) ER 2594 CLASSIFICATION: AWS A/SFA 5.9

Chemical Composition of ER 2594 Wire:

C= 0.03 max
Mn= 2.5 max
Si= 1.0 max
Cr= 24.0-27.0
Ni= 8.0-10.5
Mo= 2.5-4.5
Cu= 1.5 max
S= 0.02 max
P= 0.03 max
N= 0.20-0.30
W= 1.0 max



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Mechanical Properties Of All Weld Metal :

UTS, Mpa= 760 min
EL%= 15

TYPICAL APPLICATION OF ER 2594 WIRE (Super Duplex Wire):

- 1) A 25/9/4 type super duplex SS wire for welding of super duplex stainless UNS S 32750, 32760, SFA 2507, Zeron 100 and Casting alloys e.g. ASTM A890 Gr. 5A
- 2) Pipe work Systems, flow lines, risers, manifolds, pumps & Valves
- 3) Process equipment in offshore oil and gas industries, petrochemical plant
- 4) Also to be used on duplex 2205 grade

Packing: Tig: In cut length of 1000mm in 5kgs boxes (size: 1.6, 2.0, 2.40, 3.15mm)

Mig: Continuous wire in 12.5kgs / 15kgs Plastic Spool (size: 0.80, 1.2mm)

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