



BETANOX 2594

STAINLESS STEEL (Duplex SS)

AWS A/SFA 5.4 **E2594-15**

CLASSIFICATION:

ISO 3581-A
E 25 9 4 N L B 22

KEY FEATURES:

- Basic coated non-synthetic electrode
- Austenitic-ferritic duplex micro structure
- Excellent high strength combined with improved resistance to pitting and SSC in chloride environment
- Super duplex SS weld with N addition
- Weld metal characteristics similar to super duplex wrought and cast alloys
- Easy slag removal
- Uniform and fine ripples
- Radiographic quality weld

APPROVALS: IBR/CE

TYPICAL APPLICATIONS:

- Welding of super duplex stainless steels UNS S 32750, S 32760, SFA 2507, Zeron 100 and Casting alloys e.g. ASTM A890 Gr.5A
- Suitable for materials 1.4410, 1.4460, 1.4462, 1.4463
- Pipe work systems, flow lines, risers, manifolds, process equipment for use in offshore oil and gas industries, chemical and petrochemical plant
- Also to be used on duplex 2205 grade

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


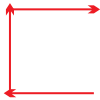
C	Mn	Si	Cr	Ni	Mo	N
0.03	1.1	0.9	26	8.9	3.6	0.25

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%	CVN Impact, J -20°C
Typical	As Welded	880	27	50
Specification		760 min	15 min	47 min

PREN: 40 min

PARAMETERS - PACKING DATA:

Ø x L, mm 2.5 x 350 3.15 x 350 4.0 x 350	Amperage, A 50-80 70-110 90-140	 AC (70 OCV) /DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Down 

Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kg each.

EQUIVALENT:

GMAW	GTAW	FCAW	SAW	
			Flux	Wire
Miginox 2594	Tiginox 2594	Miginox FC 2594	Automelt S33	Subinox 2594