

## MIGWELD 2594

MIG/MAG Wires [GMAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14343-A : G 25 9 4 NL DIN 8556 : SG-2 XCrNiMo 25 9 4 AWS A-5.9 : ER 25 9 4 W.Nr. : 1.4410		Power generation industry Petrochemical and chemical industry Shipbuilding&Offshore

- Austenitic-ferritic welding wire for 25% Cr, 7% Ni, 4% Mo alloys with low carbon content, super duplex type.
- For welding dissimilar steels, e.g. super duplex to other stainless or low alloy steels.
- Used where very high corrosion resistance is required.
- Resistant to intergranular, pitting and stress corrosion, with exceptional mechanical strength properties.
- Can be used to weld classic duplex steels where high corrosion resistance is required.

### Application

Areas of application are primarily the pulp and paper industry, offshore and gas.

### Base material



DIN	W.Nr.	AISI/ASME
G-X2 CrNiMoN25 7 4	1.4469	2507
G-X3 CrNiMoN26 6 3	1.4468	
X2 CrNiMoN22 5 3	1.4462	329LN, SM22Cr,
X4 CrNiMoNb25 7	1.4582	
G-X6 CrNiMo24 8 2	1.4463	
G-X8 CrNi26 7	1.4347	
X2 CrNiMoCuW25 7 3		100 52N+
X4 CrNiMoN27 5 2	1.4460	329 A276/A351/A473 CD-4MCu(Duplex 1A)
X2 CrNiMoCuWN25 7 4	1.4501 1.4515	Zeron100 S32760 UR52N
G-X3 CrNiMoCuN26 6 3 3	1.4517	
X2 CrNiMoCuN25 6 3	1.4507	S32520, Ferralium 255-SD50, Uranus 52N+
G-X10 CrNiMo18 9	1.4410	A182F53, S32750, SAF 2507

### Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo	N
0,02	0,40	0,90	25,00	8,50	3,80	0,25

### Typical mechanical properties

<b>Yield strength Re [N/mm<sup>2</sup>]</b>	>620
<b>Tensile strength Rm [N/mm<sup>2</sup>]</b>	>780
<b>Elongation A5 [%]</b>	>26

<b>Impact energy Kv [J]</b>	>47J (-40°C) /
<b>Welding current</b>	
<b>Welding positions</b>	
<b>Additional description</b>	PREN=38
<b>Shielding gases acc. to EN ISO 14175</b>	I1 - Ar / M12 - Ar + 0.5 - 5% CO2 / M13 - Ar + 0.5 - 3% O2 /

#### Welding parameters and packing

∅	Welding current [A]	Weight of packet [kg]
0,8	55-160	15,0
1,0	80-240	15,0
1,2	100-290	15,0

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