

TIGWELD 2594

TIG Rods [GTAW]

Stainless and high alloyed steels

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

- Austenitic-ferritic welding rods for welding 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.

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

| | |
|---|----------------|
| Yield strength Re [N/mm²] | >620 |
| Tensile strength Rm [N/mm²] | >780 |
| Elongation A5 [%] | >26 |
| Impact energy Kv [J] | >47J (-40°C) / |

Welding positions



Shielding gases acc. to EN ISO 14175

l1 - Ar /

Welding parameters and packing

| ∅ | Length [mm] | Welding current [A] | Weight of packet [kg] |
|-----|-------------|---------------------|-----------------------|
| 1,6 | 1000 / | 50-80 | 5,0 |
| 2,0 | 1000 / | 70-110 | 5,0 |
| 2,4 | 1000 / | 110-180 | 5,0 |

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