

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
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- 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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