



GMAW / GTAW SUPER DUPLEX STAINLESS STEEL
TIGINOX 2594

25/9/4 TYPE SUPER DUPLEX STAINLESS STEEL TIG ROD



CLASSIFICATION : EN ISO 14343-A AWS A/SFA 5.9 **APPROVALS :**

W 25 9 4 N L ER2594 -

KEY FEATURES :

- 25/9/4 type super duplex SS TIG rod
- Austenitic-ferritic duplex microstructure
- Improved resistance to pitting and SSC in chloride environment
- High Pitting Resistance Equivalent Number (PREN)
- Radiographic quality weld
- High tensile and yield strength

WELDING POSITION :



DCEN

Shielding Gas	Gas Flow Rate, LPM
Ar	10-15

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
- Pipe work systems, flow lines, risers, manifolds, pumps & valves
- Process equipment in offshore oil and gas industries, petrochemical plant
- Also to be used on duplex 2205 grade

STORAGE / HANDLING :

Keep dry during storage and handling

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	C	Mn	Si	Cr	Ni	Mo
Specification	0.03 max	2.5 max	1.0 max	24.0-27.0	8.0-10.5	2.5-4.5

	Cu	S	P	N	W	
Specification	1.5 max	0.02 max	0.03 max	0.20-0.30	1.0 max	

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%	PREN
Specification	As Welded	760 min	15 min	40 min

PACKING DATA :

Ø, mm	Primary Box, Kg	No. of Primary Boxes	Net Wt. of Carton, Kg
1.6 x 1000	5	4	20
2.0 x 1000	5	4	20
2.5 x 1000	5	4	20
3.15/3.2 x 1000	5	4	20

EQUIVALENT :

SMAW Electrode: **Betanox 2594**