

TIGINOX 2594 / MIGINOX 2594

Classification

AWS A/SFA 5.9 : ER 2594

Characteristic

A 25Cr, 9.2Ni, 3.5 Mo, 0.25N stainless steel wire for TIG/MIG welding of Super Duplex Stainless steels. These stainless steels have PREN at least 40, which brings it into category of “super duplex stainless steel”. These stainless steels have high resistance to chloride induced stress corrosion cracking and pitting attack in chloride environment

Typical Application

This wire is suitable for welding of super duplex stainless steels UNS S32750 and 32760 (wrought), and UNS J93380, J93404 (cast). It can also be used for welding of UNS S32550, J93370, J93372 when not subjected to sulfurous or sulfuric acids in service. It is specially used for root runs in pipe to weld standard duplex stainless steels such as UNS S32205 and J92205.

Wire Chemistry

C	S	P	Mn	Si	Cr	Ni	Mo	N	Cu	W
0.03 max	0.02 max	0.03 max	2.5 max	1.0 max	24.0-27.0	8.0-10.5	2.5-4.5	0.20-0.30	1.5 max	1.0 max

Properties of weld metal with 100% Argon gas shielding Current Condition: TIG : DC (-) MIG : DC (+)

Classifications:

All Weld Mechanical Properties As welded condition

UTS MPa	760 min
Elongation % (4d)	15 min
The chemistry and mechanical properties of the weld metal will vary with the type of shielding gas used.	

Packing Specifications

Supplied in D 300 plastic spools - layer wound / Weight - 12.5 Kg

Each plastic spool is sealed in a polyethylene bag and then packed in a corrugated box which is shrink-wrapped.

Packing Specifications for MIGINOX 2209

Dia., mm	0.8	1.2	1.6	2.0
Net wt per spool,kg	12.5	12.5	12.5	12.5

Packing Data for TIGINOX 2209

Dia., mm	2.4	3.2
Length,mm	1000	1000
Net wt per tube,kg	5	5
No of Plastic Tubes per Box	4	4
Net wt,Box,kg	20	20



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