

80%Ar - 20%CO<sub>2</sub> / 100%CO<sub>2</sub>

EN ISO 17633-A T 25 9 4 N L P C/M 1

AWS A5.22 E2594T1-1/-4

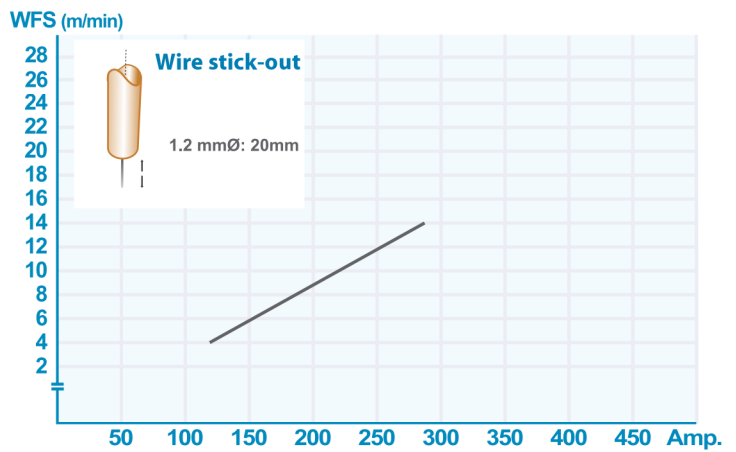
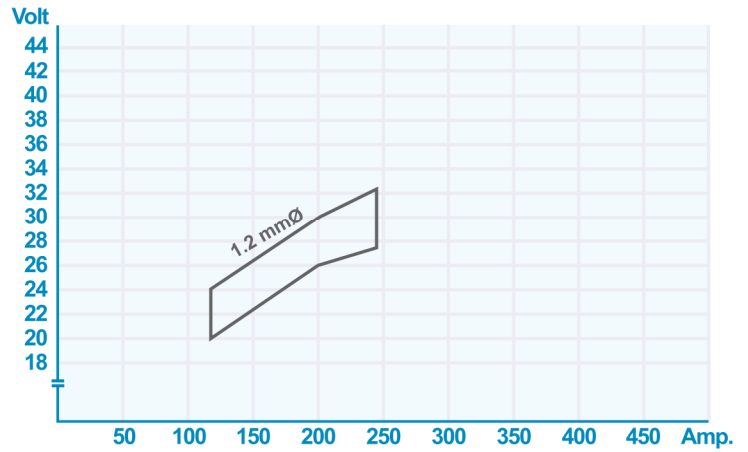
1.4501

## Description and Application

PREMIARC™ DW-2594 is a rutile flux cored wire designed for welding super duplex stainless steel EN 1.4410 /ASTM 32750 grade and EN 1.4501 / ASTM 32760 grade.

This wire operates with a stable, spatter free arc producing bright, smooth weld bead surfaces and self releasing slag.

## Recommended Parameter Range, for flat position\*



## Typical Chemical Analysis (wt. %)\*

C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FNW
0.03	0.50	1.20	0.019	0.004	9.7	25.9	3.90	0.25	-	48

## Typical Mechanical Properties\*

	R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	CV(J)-40°C
	701	906	27	39
Guarantee	min.550	min.760	min.18	min.27

\* The above values and parameters are for all weld metal produced using Ar+CO<sub>2</sub> shielding gas

## Welding Positions



## Approvals

LR	DNV	BV	GL	ABS	R.M.R.S	Others
-	-	-	-	-	-	-