

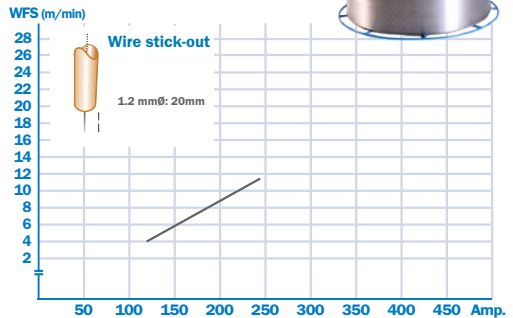
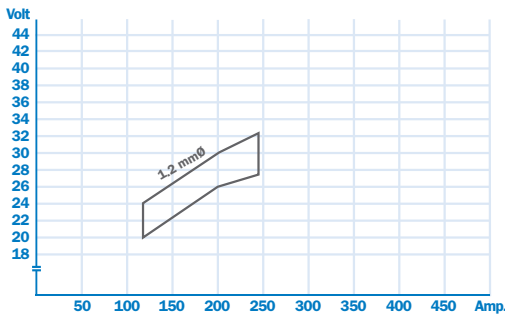
Description and Application

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. %)*

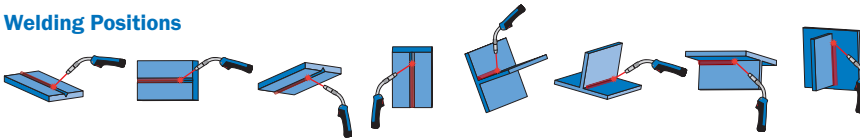
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FNW
0.03	0.50	1.20	0.019	0.004	9.7	25.9	3.90	0.25	-	48

Typical Mechanical Properties*

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-40°C
Guaranty	701	906	27	39
	min.550	min.760	min.18	

* The above values and parameters are for all weld metal produced using Ar+CO₂ shielding gas

Welding Positions



Approvals

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