

Filler rod and wire

Features:	▪ Suitable for super duplex stainless steel (S32750, S32760, etc.)
Classification:	AWS A5.9 ER2594
Shielding gas:	Ar or Ar-2%N ₂
Identification color:	1st Red, 2nd Blue
Polarity:	DCEN

Packaging data

φ mm	Spool		Tube	
	kg	kg	Length mm	g/piece
1.2	10	5	1,000	9
1.6	-	5	1,000	16
2.0	-	5	1,000	25
2.4	-	5	1,000	36
3.2	-	5	1,000	64
Volume mm	240W, 110H, 240L		40W, 35H, 1015L	

Composition (rod and wire mass%)

	Typical	Guaranty ^a
C	0.01	0.03
Si	0.4	1.0
Mn	0.6	2.5
P	0.02	0.03
S	<0.01	0.02
Ni	9.2	8.0~10.5
Cr	24.8	24.0~27.0
Mo	3.8	2.5~4.5
Cu	0.1	1.5
N	0.26	0.20~0.30

Note: ^aSingle values are maximum.

Welding parameters (A)

φ mm	
1.2	50~100
1.6	100~200
2.0	100~200
2.4	150~250
3.2	200~300

All-weld mechanical properties

	Typical (Ar-2%N ₂)
0.2%YS (MPa)	646
TS (MPa)	859
EI on 4d (%)	38
IV -50°C (J)	171

Approvals

DNV	MG (Super duplex)