

FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SS-2594 is a duplex stainless steel comprised of austenite and ferrite steels, the weld metal contains 26%Cr-10%Ni-3.5%Mo-0.2%N.
- The advantage of strength and toughness, and better corrosion resistance than SS-2209.
- PREN (Pitting Resistance Equivalent Number) >40.
- Apply for offshore platform, pressure container, chemical equipment and pipelines, seawater desalination industry, pharmaceutical industry, petrochemical industry, natural gas as pumps, pressure containers, valves, heat exchangers, and the chlorine gas equipment.
- It is suitable for UNS S32750 (as Alloy 2507), UNS J93404, A890 GR. 5A.

NOTE ON USAGE :

- Use CO₂ within gas purity of 99.8% upward for gas shield, and the flow with 20~25 l/min.
- When use mixed gas (80%Ar+20%CO₂), the welding voltage should be less 1~2V than CO₂ gas, the electrode extension less than 20mm to prevent worm hole.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) : (CO₂)

C	Mn	Si	P	S	Ni	Cr	Mo	N
0.03	0.85	0.78	0.030	0.006	8.30	25.20	3.48	0.22

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (CO₂)

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %
850(86.7)	25

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Parameters	Diameter (mm)	1.2		1.6	
		F, H	V, OH	F, H	V, OH
Voltage (Volt)		23-36	22-26	28-36	-
Current (Amp)		130-250	120-160	180-300	-