SS-2595

AWS A5.4 E2595-16
EN ISO 3581-A E 25 9 4 W N L R 1 2
GB T983 E2595-16

COVERED ELECTRODES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SS-2595 is a titanium oxide low hydrogen electrode, the weld metal contains 25%Cr-8.5%Ni-4%Mo-N the duplex stainless steel comprised of austenite and ferrite steels.
- It is suitable for AC (Alternating Current), the component of micro-copper and wolfram for better corrosion resistance, strength, and toughness.
- The advantage of strength and toughness, and better corrosion resistance than SS-2209.
- PREN (Pitting Resistance Equivalent Number) >41.5 .
- 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 :

- Rebake the electrodes at 250 ~ 300°C for 1 hour and keep it at 100~150°C prior to use.
- With lower current is to properly keep the dilution of the parent metal for welding crack.

WELDING POSITION :

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni	Cr	Mo	N	Cu	W
0.032	0.82	0.69	0.030	0.009	8.3	25.5	4.1	0.24	0.6	0.75

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

TENSILE STRENGTH $N/mm^2(Kgf/mm^2)$	ELONGATION RATE %
920(93.9)	20

SIZE AND RECOMMENDED CURRENT RANGE : AC or DC(+)

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		300	350	350	350
Current (Amp)	F	60-85	80-120	100-150	140-170
	V & OH	60-80	65-105	95-140	-