

MIDALLOY CHROMAX E2594-16 COATED ELECTRODE

CLASSIFICATION

- AWS 5.4 Class E2594-16 / ASME SFA 5.4 Class E2594-16
- UNS W39594 F No. 5 A No. 8

DESCRIPTION

- MIDALLOY CHROMAX E2594-16 is super duplex, AC-DC Titania Coated Electrode
- MIDALLOY CHROMAX E2594-16 has good corrosion resistance in severe conditions
- Excellent resistance to stress corrosion cracking resistance, pitting and general corrosion.

APPLICATION

- For welding or repairing Type 2507 (UNS S32750) cast UNS J93404 and similar compositions
- Dissimilar metal combinations of carbon steel and stainless steels to 22Cr and 25Cr duplex stainless steels.

TYPICAL CHEMISTRY

C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
0.03	25.0	9.1	3.80	1.30	0.65	.015	0.005	0.22	0.08

PRE No. >40

TYPICAL MECHANICAL PROPERTIES (as welded all weld metal)

TENSILE STRENGTH	115,500 PSI
YIELD STRENGTH	105,000 PSI
ELONGATION IN 2"	25%
IMPACTS @ 72 F°	30 FT-LBS

WELDING PARAMETERS

DIAMETER	VOLTAGE	AMPERAGE	
		FLAT	VERTICAL & OVERHEAD
3/32"	24-28	70-85	65-75
1/8"	26-30	85-110	80-90
5/32"	28-32	110-140	100-120
3/16"	28-32	120-160	110-130

STANDARD PACKAGING

- 3/32" 8 lb. can / 48 lb. box
- 1/8" 10 lb. can / 60 lb. box
- 5/32" 10 lb can/ 60 lb box
- 3/16" 10 lb. can / 60 lb. box

3/2/11

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