

MIDALLOY ER2594 Bare Wire

CLASSIFICATION

- MIDALLOY ER2594 conforms to AWS / ASME SFA 5.9 2006. Reference EN12072 2594LN.
- A8 F#6

DESCRIPTION

- MIDALLOY ER2594 is a super duplex stainless steel is used for GTAW, GMAW and SAW.

APPLICATIONS

- MIDALLOY ER2594 is utilized to weld super duplex stainless such as SAF 2507 (UNS 32750) and other 25% Chromium duplex stainless steels (i.e. UNS 32760, UNS 32550, and UNS 31260).
- MIDALLOY ER2594 is also utilized for corrosion resistance overlays.

TYPICAL CHEMISTRY

C	Cr	Ni	Mo	Mn	Si	N
.014	25	9.5	3.9	.5	.35	.22

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	123,300 PSI
YIELD STRENGTH	97,400 PSI
ELONGATION IN 2"	28%

- Impacts 90 Ft-lbs @ 20°C

PROCEDURE INFORMATION

No special preheat, max inter-pass temperature 500°F
 Special Heat Input Restriction - 5 KJ/inch min. 40 KJ/inch max.
 Avoid very rapid cooling for optimum weld metal properties
 Post weld heat treatment (Quench anneal) may be required for thick sections
 Submerged-arc welding wire is done with Record IND 24 Flux

PACKAGING

- TIG 10 lb. tube / 60 lb. carton
- MIG 30 lb. spool
- SUB-ARC 60 lb. coil

2-25-15

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