TECHNICAL DATA SHEET

parweld
WELDING THE FUTURE

XP ER 2594

STAINLESS STEEL

CLASSIFICATIONS

EN ISO 14343-A	AWS A5.9
W 25 9 4 N L	ER2594

KEY FEATURES AND APPLICATIONS

- Solid corrosion-resistant, Super Duplex wire for welding austenitic-ferritic stainless alloys of the 25% Cr, 7% Ni, 4% Mo, low C types.
- Offers similar chemical and mechanical properties to wrought super duplex alloys like 2507.
- This alloy is primarily used in applications that demand exceptional corrosion resistance.
- Ideal for service temperatures up to 250°C max.
- Typical used in the oil and gas industries, desalination, chemical processing, drug manufacturing, and paper production industries.

BASE MATERIALS

1.4507, 1.4410, 1.4468, 1.4515, 1.4517, 1.4501, 1.4467, 1,4569, 1.4508

X2 CrNiMoCuN 25-6-3, X2 CrNiMoN 25-7-4, GX2 CrNiMoN 25-6-3, GX2 CrNiMoCuN 26-6-3, GX2 CrNiMoCuN 25-6-3-3, X2 CrNiMoCuWN 25-7-4, X2CrMnNiMoN26-5-4, X 2 CrNiMoN 26 7 4, GX2CrNiMoCuWN25-8-4

UNS S32520, S32550, S32750, S39274, S39277, S39553, S32760, J93380

Ferralium 255, SAF 2507, ZERON 100, UR 76 N, SM22Cr, SAF 2507, Alloy 2507, Alloy 2594

CHEMICAL COMPOSITION OF WIRE %

	C	Si	Mn	P	S	Cr	Ni	Mo	N	Cu	W
MIN	-	-	-	-	-	24.0	8.0	2.5	0.20	-	-
MAX	0.03	1.0	2.5	0.03	0.02	27.0	10.5	4.5	0.30	1.5	1.0

Single values are maximum values according to EN ISO 14343

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL VALUES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)
≥550	≥620	≥18

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

OPERATING DATA

Shielding Gases	Polarity
EN ISO 14175 - I1	DC-

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Length (mm)	Weight (kg)	Packaging
XP30392	1.6	1000	5	PAP 20 Tube
XP30394	2.4	1000	5	PAP 20 Tube
XP30396	3.2	1000	5	PAP 20 Tube

MADE IN EU