



# FW 2594



**CODIFICATION: AWS/SFA 5.9  
ER2594**

### CHARACTERISTICS AND APPLICATIONS:

FW 2594 is a solid wire for TIG welding, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. The weld metal exhibits high strength, high impact energy, and resistance to stress corrosion cracking, pitting, and crevice corrosion. The weld metal possesses excellent corrosion resistance in marine & paper environments. Examples of application areas are: Oil and gas industry, Off shore plat forms, Petrochemical plants, Mechanical and structural components. It is suitable for welding

- ASTM A890/A995 Gr. 5A, CE3Mn, UNS J93404
- Super Duplex 2507, UNS S32750, EN 1.4410, NF Z3 CND 25-06AZ, SS2328
- ASTM A890/A995 Gr. 6A UNS 32760, J93380, CD3MWCuN

### CHEMICAL COMPOSITION OF SOLID WIRE (%):

Element	C	Mn	Si	P	S	Cr	Ni	Mo	Cu	N	W
Range	0.03 Max	2.5 Max	1.00 Max	0.030 Max	0.020 Max	24.0- 27.0	8.0- 10.5	2.5- 4.5	1.50 Max	0.20- 0.30	1.00 Max
Typical	0.025	1.50	0.50	0.015	0.010	25.0	9.0	3.5	0.30	0.22	0.10

### MECHANICAL PROPERTIES OF ALL WELD METAL:

Property	UTS (MPa)	Elongation (L=4d) %	CVN Impact (Joules) at 20°C
Range	760 Min	15.0 Min	45 Min
Typical	790	23.0	60

**PITTING RESISTANCE NUMBER:** Meet the requirement of PREN ≥ 40

**CORROSION PROPERTY:** Weld metal meets ASTM A262 Practice C and ASTM G-48A

**FERRITE (FN) :** 30-60

**SHIELDING GAS :** Argon

**WELDING POSITIONS :**

**CURRENT CONDITIONS :** DCEN

### PACKING:

<b>Standard Size</b>	Diameter 1.6 mm, 2.0 mm, 2.5 mm & 3.2 mm in cut lengths of 1000 mm each.
<b>Quantity</b>	5 kgs wire put in an air-tight polythene bag and finally packed in a plastic container. Identification – AWS code is punched on both the sides of wire.

**An ISO 9001: 2008 certified company**

**D & H Sécheron Electrodes Pvt. Ltd.**

44-46, Industrial Estate, Kila Maidan, Indore-452 006, India, Ph: 0731 2412331-2, 4229222 Fax: 0731 4229260  
e-mail: info@dnhsecheron.net Website: www.dnhsecheron.com

February 2, 2017 Rev. 02