

CSF-2594P

Super Duplex stainless steel

AWS A5.22 E2594T1-1/4

Applications

CSF-2594P is suitable for welding of low carbon 25%Cr-9%Ni-3%Mo-N super duplex stainless steel.

Characteristics

- (1) CSF-2594P is flux cored wire and designed for All-position welding with CO₂ gas Shielding.
- (2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.

Notes on usage

- (1) The optimum flow of CO₂ for Shielding is 20~25ℓ/min.
- (2) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- (3) Keep the distance between tip & base metal at 15~25mm.

Typical chemical composition of weld metal (%)

(Shielding Gas : 100%CO₂)

C	Mn	Si	Cr	Ni	Mo	N	W	F/N
0.03	1.0	0.6	24.4	9.8	2.8	0.23	0.7	50

Typical mechanical properties of weld metal

(Shielding Gas : 100%CO₂)

YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL %	IV (J)
			0℃
725	880	26.0	60

Size & recommended current range (DC +)

Dia. mm (in)	Current(A)	Voltage(V)	Welding Speed(cm /min)
1.2(0.045)	150~300	24~33	20~60
1.6(0.062)	200~400	24~33	20~60